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SPE JOURNAL

The Official Publication of the Society of Plastics Engineers, Inc.

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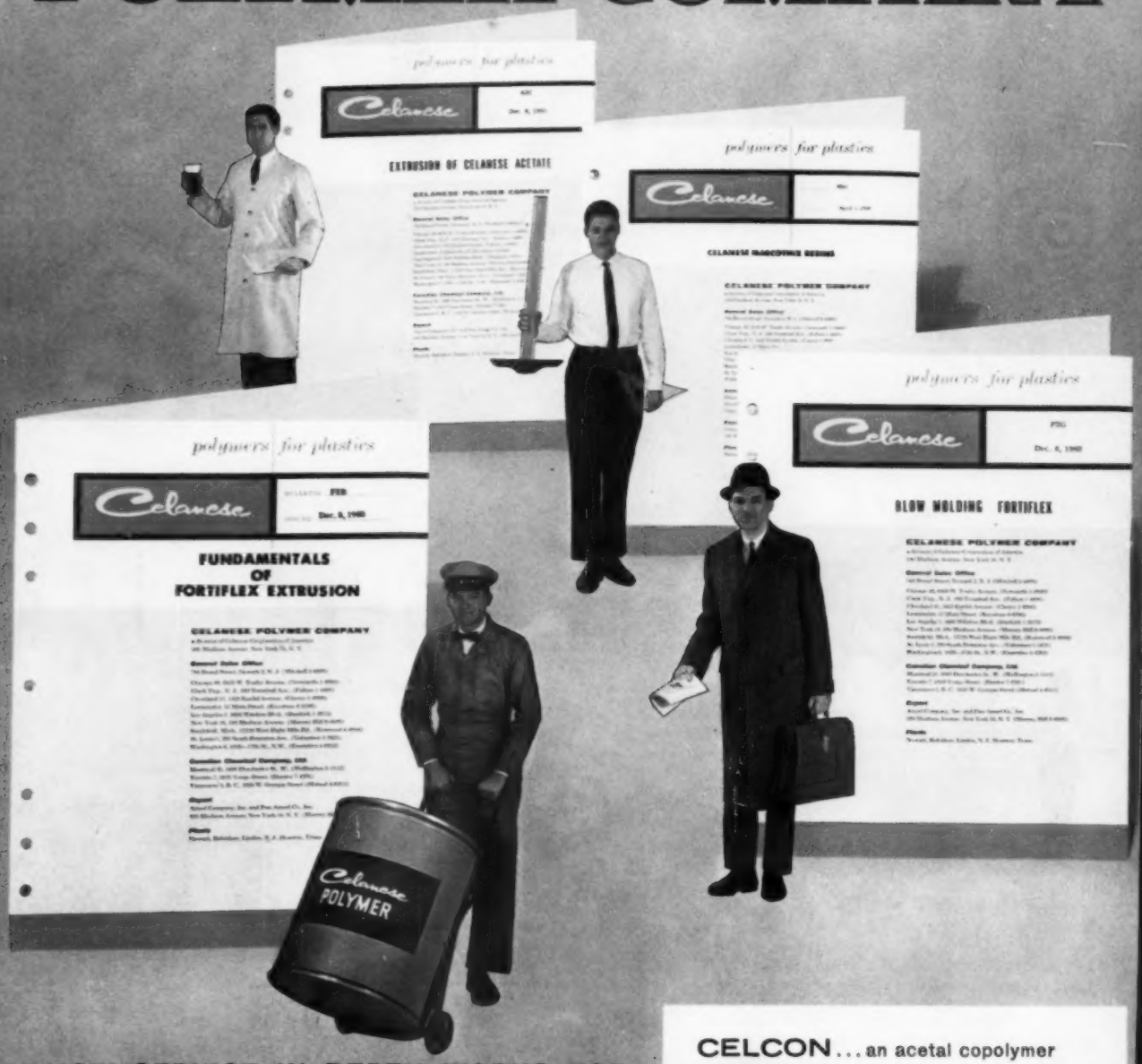

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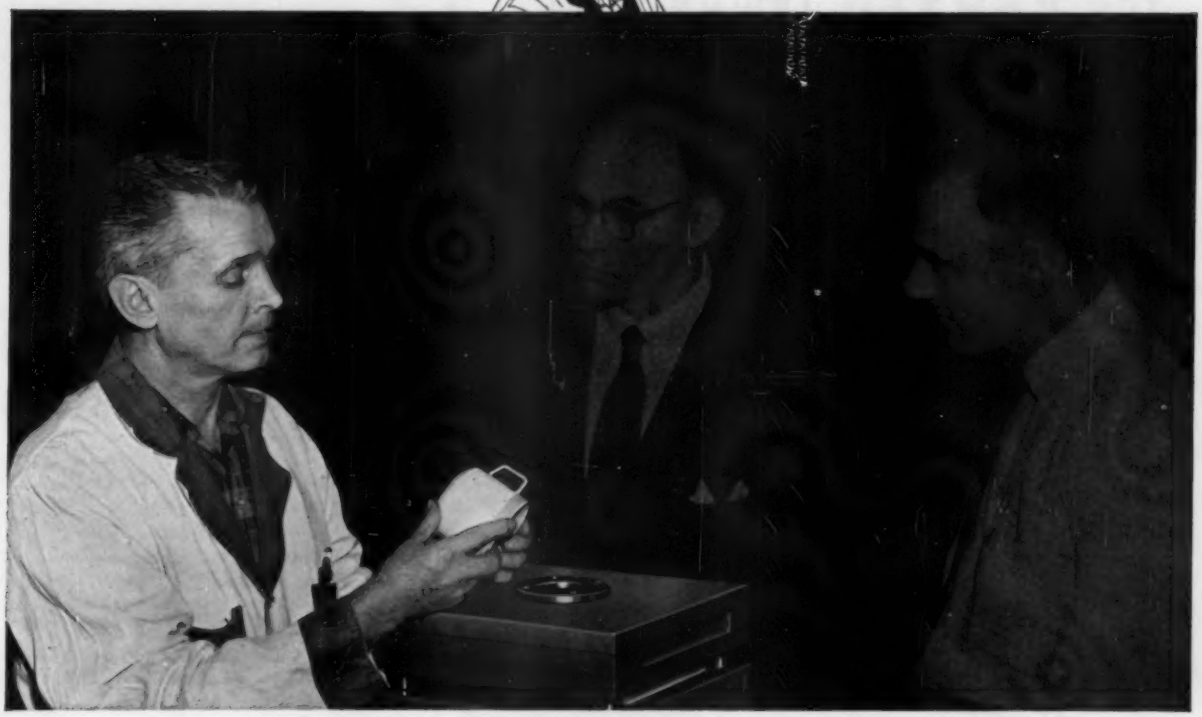

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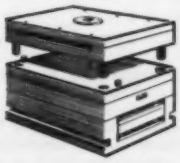

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SPE JOURNAL
VOL. 17 • NO. 8
AUGUST 1961

SPE Journal Newsletter **719**

REGIONAL TECHNICAL CONFERENCE
Plastics foams, Oct. 5, 1961 sponsored by the Buffalo Section
New technical developments in rigid and flexible foams **725**

SPE Journal Features

Speaking of Extrusion—Vented Extruder Design
L. B. Ryder, Celanese Polymer Co.
Venting mechanisms and their influence on screw design discussed **731**

Molding Cycles—Molding Large Rectangular and Flat Items from High Density Polyethylene
J. V. Smith, C. G. Williams and L. R. Alexander, Phillips Chemical Co.
Special techniques described for facilitating injection molding of high density polyethylene **735**

Reinforced Plastics—RP Aviation Gas Turbine Compressor Housing
C. H. Vondracek and R. W. Sampson, Westinghouse Electric Corp.
Lightweight, non-corroding and low cost reinforced plastics have structural applications in jet engines **743**

Standards for Plastics—Long Term Working Stress of Thermoplastic Pipe
Frank W. Reinhart, National Bureau of Standards
A more realistic standard presented to help increase acceptance of thermoplastic pipe by designers ... **751**

Technical Articles

The Effects of High Vacuum and Ultraviolet Radiation on Plastic Materials
Norman E. Wahl, Cornell Aeronautical Laboratory, Inc.
The properties of phenolic and polyester glass fiber laminates are not affected significantly at high altitudes **759**

Laboratory Processing Studies of Polyethylene, Polypropylene and Nylon 6 Coatings
John F. Morris, Spencer Chemical Co.
Properties and uses of the various coating materials are appraised **762**

Hydraulic Fluids, Fact and Fancy
George Arbocus, E. F. Houghton and Co.
Proper evaluation of your hydraulic fluid will result in a more economical operation **767**

Roster of the Membership SUPPLEMENT ..... *following 778*

Your guide to:
National Officers — Committee Chairmen
Geographical Listing — Alphabetical Listing

News of SPE

PAG Progress—PAG Develops Comprehensive Program to Serve Automotive Industry
Travis Meister, Chairman, Plastics in the Automotive Industry PAG, (Ford Motor Co.) **773**

Departments

Editorial **713**
Letters to the Editor **717**
Technical Meetings Calendar **775**
Section News **919**
About Members **922**
New Equipment and Materials **925**
Book Reviews **929**
Employment and Service Guide **936**
Advertisers' Index **938**

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The Metric System— Vs. the English System

There is currently great discussion and considerable debate in this country over which system—the metric or English—must ultimately be adopted. Final outcome of all that is taking place will have a significant impact on the plastics industry.

Proponents of the metric system say that it is a simple decimal system of weights and measures based on the internationally accepted units for the meter, kilogram, and second. The English system, they say, is the outgrowth of an old tribal custom based on the length of the King's foot.

Reasons advanced in favor of the plastics industry adopting the metric system are that the system is easier to use, it is simpler to convert, and easy to teach and use. Further, with the growing international role of science and technology, one system—the metric—can result in much constructive achievement.

There are some who think that use of the metric system on plastics machinery specifications could lead to greater exports of U.S. machines, the argument being that foreign countries, other than the United Kingdom, want only those machines which have specifications in the metric system. Most plastics equipment manufacturers, feel however, that the major limitations in developing export markets are high costs and a reluctance to finance poor credit risks.

What is the status in the plastics industry today? Significantly, it is beyond the talking stage. ASTM Committees D-20 (plastics), D-11 (rubber and rubber products), and D-9 (electrical insulation materials) all operate on what is known as an obsolescence basis, writing specifications in the metric systems and carrying English equivalents. An agreement exists between The Bell Telephone Laboratories and Western Electric which requires that all plastics purchased for use in wire and cable carry specifications in the metric system. SPE's own official attitude will be decided soon by an AD Hoc Committee headed by Donald Eells of the Du Pont Co.

Whatever the influence of the plastics industry in demonstrating the advantages to be gained by using the metric system, there is a reasonable doubt that a complete changeover by American industry could be made within the near future.

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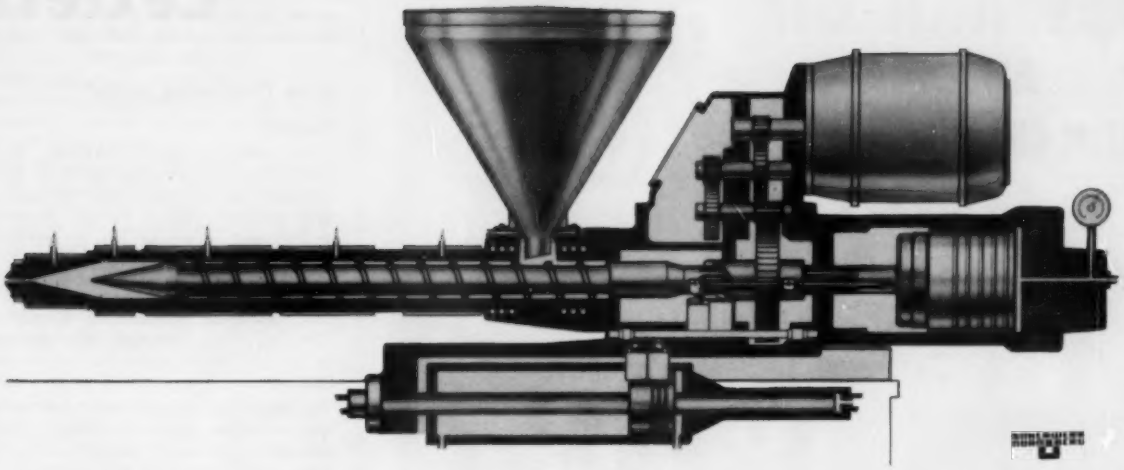

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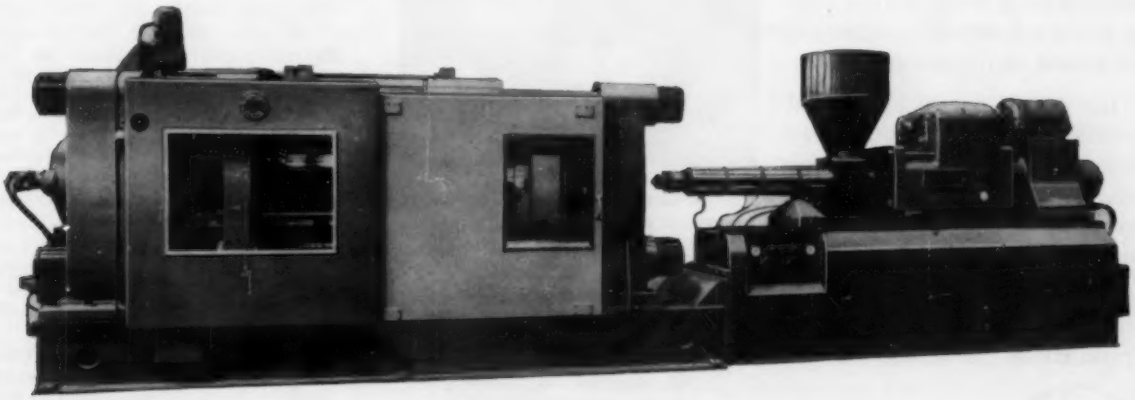

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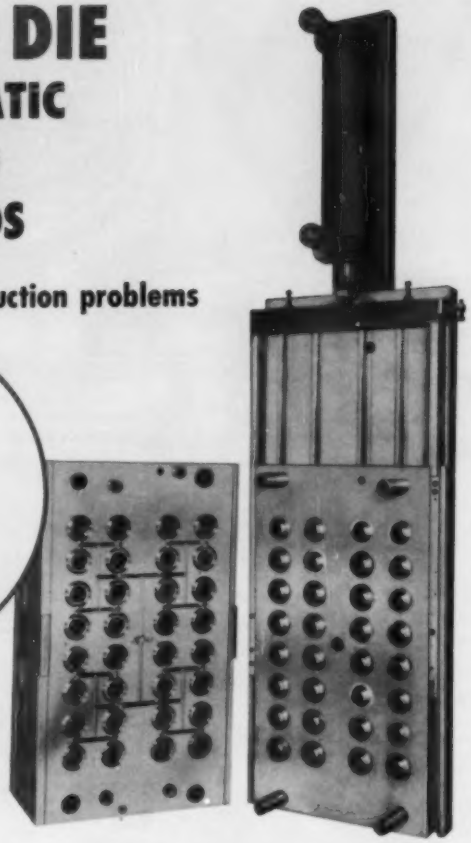

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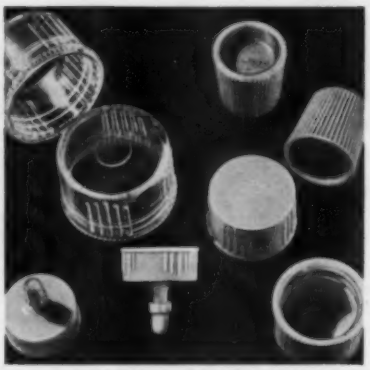

Newark Die molds are used to make a wide variety of screw caps of which these are typical.

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Letters

Screw Plasticizing Boom?

Dear Sir:

An article entitled Movable Screw Plasticizing Boom written by A. R. Morse appeared in the June 1961 issue of the SPE Journal. This is a very interesting article, and I would like to receive a copy of it.

Francis Crescenzo
Assistant Director of Engineering
Package Machinery Co.

Dear Sir:

I was very much interested in the special feature article on Movable Screw Plasticizing Boom. I would like to have three extra copies of this article.

Wm. Schmid
Owens-Illinois

Introduction to Extrusion

Dear Sir:

I would be pleased to receive a reprint of the article entitled An Introduction to Extrusion for Blow Molders, appearing in the May 1961 issue of the SPE Journal.

A. F. Schmelzle
Minnesota Mining and Manufacturing Co.

Dear Sir:

We would appreciate very much your sending a reprint of the article an Introduction to Extrusion for Blow Molders.

Ing. Jaime Lomelin
Monsanto Mexicana, S. A.

Dear Sir:

Will you please send us two reprints of the article by R. D. Sackett entitled An Introduction to Extrusion for Blow Molders. Our Plant Extrusion Engineer and our Research Unit both find this article necessary for their files.

Alice F. Laubach,
Librarian
American Enka Corp.

Dear Sir:

We would like to receive a reprint, or if possible, reprints of the article An Introduction to Extrusion for Blow Molders.

R. N. Pim, Manager
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Dear Sir:

It woul be fair to assume that the Casting Bibliography published in your May issue is intended to be complete and accurate. There is no disclaimer to the contrary. The author does not say

that the Bibliography is "selected." He does not say that he will cite literature dealing only with certain phases of the subject. Nor does he say that he will cite literature primarily from certain sources and only to a limited extent from others. However, some palpable inaccuracies cast doubt on the value of the entire compilation.

I will limit my comments to the accuracy of Mr. Ferrari's (Edward Ferrari, Chairman, Casting and Plastics Tooling PAG) references to the literature on casting resins published in ELECTRICAL MANUFACTURING (since October 1960 known as ELECTRO-TECHNOLOGY). He credits our magazine with two articles published in 1957 and 1958 respectively and for a third item he attributes to us a book published by McGraw-Hill, with whom we have no connection whatsoever. The facts are that since 1950 we have published more than 20 full-length feature articles on this subject. As a member of SPE since 1947 (and currently a member of the Executive Committee of the PAG on Electrical Insulation) I am distressed that I have to be critical of material published in the Society Journal.

Alex. E. Javitz
Special Features Editor
ELECTRO-TECHNOLOGY

Editor's Note

We asked Mr. Ferrari, Chairman of the Casting and Plastics Tooling PAG to comment on Mr. Javitz's letter. His comments appear below. Mr. Javitz also supplied what he considered an addendum to this bibliography. The addendum will be in the September issue.

This bibliography was started in 1958 at the first annual meeting of the PAG on Casting and Plastics Tooling and was originally to be a compilation of pertinent literature on casting from 1951-1957. To avoid duplication it was decided not to include casting pertaining to electrical insulation such as potting, encapsulating, embedment, and impregnation. Obviously this would be the work of the PAG on Electrical Insulation.

You are correct in calling to our attention the error committed in placing Henry Lee and Kris Neville's book on Epoxy Resins under the heading ELECTRICAL MANUFACTURING. My aplogies to Messrs. Lee and Neville, McGraw-Hill, and ELECTRO-TECHNOLOGY. You assume that the Casting Bibliography is complete and accurate but mention that "there is no disclaimer to the contrary." No bibliography should ever be labeled complete since that would imply that no further technical development is forthcoming. Accuracy in this case is totally dependent on the human factor which is not infallible. However, it should have been stated that the material was "selected."

Edward Ferrari, Chairman
Casting and Plastic Tooling PAG

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To speed up tooling and cut costly machining, filing and polishing time . . . many plants choose die hobbing. One master hob provides any quantity of steel molds or dies, all of them exactly alike and each requiring a minimum of hand or machine finishing. Because hobbing is a cold flow, high pressure operation (over 100 tons per sq. in.) each cavity acquires a closer surface grain structure. This assures faithful retention of the finest detail . . . plus a luster that would be difficult to accomplish by machine finishing.

WRITE for your free copy of "How and When to Hob." Or let us discuss directly how Newark's complete die hobbing facilities and experience with all sizes and types of cavities may benefit you. No obligation, of course.

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Mr. Lorentz, right, and Mr. Anthony Robinson, Supervisor of Styroflex Division, discuss production results as displayed on the BetaMeter Control Console. Above inset shows BetaMeter in operation.

"Quality is our prime consideration at Natvar"

All Styroflex operations at Natvar are carefully controlled to uphold quality standards.

". . . and Curtiss-Wright BetaMeter gives us round-the-clock quality control of our custom-formulated Styroflex film," states Mr. Robert C. Lorentz, plant manager of Natvar Corporation, Woodbridge, New Jersey.

Natvar Corporation is a leading manufacturer of flexible insulation for electronic and electrical industries throughout the world. For the precise production of Styroflex film, Natvar relies on Curtiss-Wright BetaMeters to assure and maintain exact uniformity down to 0.00025" film.

The BetaMeter is ideal for all applications where close tolerances and finest quality are of prime importance. Variations in thickness are instantly detected and recorded during actual production. Material being measured is not contacted nor is the process affected in any way. The Curtiss-Wright BetaMeter permits optimum control of production variables, improves quality and increases profits by reducing costly scrap losses.

Automatic process control equipment is available for all standard BetaMeter measuring systems.

For information on how the Curtiss-Wright BetaMeter can benefit your plastic film, sheet or coated stock operation, phone SWinburne 9-0500 or write.

Curtiss - Wright Mark II BetaMeters, for handling up to 36" webs, are priced from $4985 (Strip-chart recorder included).

Princeton Division CURTISS WRIGHT CORPORATION Princeton, New Jersey

In CANADA: Canadian Curtiss-Wright Ltd., 287 Horner Ave., Toronto, Ontario

SPE JOURNAL NEWSLETTER

reading time
1 minute

New Urethane Catalysts

Stannous octoate will be getting stiff competition as a catalyst for urethane foams. Ferro Chemical is expected to announce a new catalyst within the next 3 months at about one-half the price of stannous octoate. Heyden Newport Chemical's new catalyst is reported to have superior storage stability and resistance to oxidation and hydrolysis.

Polyethylene Butt-Fusion

A new technique to join lengths of pipe in the field has been developed by the Phillips Chemical. An aluminum plate is heated to 400°F and inserted between the pipe-ends for about thirty seconds. These molten ends are then pressed together to form a high quality joint. This Butt-Fusion technique is expected to help induce greater acceptance of linear polyethylene as a piping material.

Fluorocarbon Monofilaments

Brush applications for "Teflon" FEP fluorocarbon resin monofilaments are being studied by du Pont. Potential areas of use are for corrosive elements, extreme temperatures and sticky ingredients. Diameters of five and eleven mills are now available and other sizes are obtainable for development purposes.

New Isocyanate Capacity

The nation's isocyanate capacity is increasing. Allied Chemical plans to build a 15 million pound plant in Southern California while Mobay has reportedly expanded their plant facilities from 25 to 40 million pounds per year with plans to increase total capacity to 50 million pounds this fall. Nopco should have its new 10 million pound plant on stream by 1962. Finally Du Pont has announced construction plans for a TDI plant in Londonderry, Northern Ireland, which when completed will release more isocyanate to the domestic market. Will anyone else plan increased capacity?

Fire Retardant Foam

Hooker's fire-retardant "Hetrofoam" is primarily formulated from "Het" acid which introduces a high chlorine content as part of the polymer structure. Immediate uses are: electrical appliances, refrigerators, paneling and insulation. Wide-spread use for construction purposes will depend on consumer acceptance and price competition from other construction materials, building codes and fire insurance factors.

new technical ideas • trends • industry news

In these flame tests, one epoxy strip ignites and burns rapidly; the other, containing Aroclor, won't ignite at all.

AROCLORS are COMPATIBLE with virtually all plastics resins • polyvinylidene chloride • cellulose acetate-propionate • polyvinyl acetate • chlorinated rubber • ethyl cellulose • benzyl cellulose • polystyrene • nitrile rubber • phenolics • polyamides • epoxies • acrylics • urethanes • polyesters • polyethylene • nitrocellulose • polyisobutylene • styrene-butadiene • polyvinyl butyral • polyvinyl chloride • cellulose acetate-butyrate

HOW TO "BUILD IN" HIGH RESISTANCE TO FIRE AND CHEMICALS WITH LOW-COST AROCLOR® PLASTICIZERS AND RESIN EXTENDERS

AROCLOR *chlorinated* polyphenyls—liquid or solid—offer remarkable *inertness*. They don't burn, evaporate, hydrolyze, or oxidize. They defy strong acids and alkalies. They blend readily with nearly all resins, solvents, plasticizers, and other plastics-compounding ingredients. You can choose from 13 standard AROCLORS—to impart outstanding flame retardance, chemical resistance, and other desired properties to your plastics compounds and protective coatings . . . *at low cost.*

NONBURNING EPOXIES

Aroclors are fully compatible with epoxy resins. Combined with a small amount of antimony oxide, they produce *nonburning* compositions. Aroclor 5460 yields epoxies with optimum compressive strength. Aroclor 1221 greatly improves flexibility.

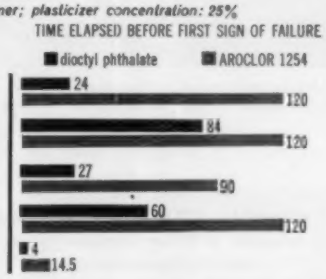
	AMINE-CURED EPOXIES		PHTHALIC ANHYDRIDE-CURED EPOXIES	
formulation	**control**	**modified**	**control**	**modified**
liquid epoxy resin	100	100	100	100
diethylenetriamine	13	13	...	...
phthalic anhydride	...	...	75	75
antimony oxide	...	5	...	5
DMP 30 (Rohm & Haas)	...	...	0.1	0.1
AROCLOR 1260	...	15	...	...
AROCLOR 5460	...	...	...	15
properties				
compressive strength, *psi*	43,000	38,150	23,400	40,700
flexural strength, *psi*	20,100	22,100	16,900	19,000
heat distortion, °C.	117.5	92	143	135
FLAMMABILITY—*inches per minute* (ASTM D635-56T)	0.82	NON-BURNING	0.6	NON-BURNING

EXTENDERS FOR PVC

Aroclors are especially effective as secondary plasticizers or extenders for polyvinyl chloride. Aroclor 1262, used 1:3 with dioctyl phthalate, sharply reduces migration to nitrocellulose lacquers. All Aroclor compounds can be used to improve the chemical resistance of vinyl chloride–vinyl acetate coating formulations.

TYPICAL CHEMICAL RESISTANCE*

vinyl chloride/vinyl acetate copolymer; plasticizer concentration: 25%



***Plotted from independent evaluation data by the Northwestern Paint and Varnish Production Club** (The Official Digest, Nov. 1955).
Conclusion: **"The Aroclor 1254 had the best all-around chemical resistance."**

SELF-EXTINGUISHING POLYESTERS

The highly chlorinated Aroclors (1260, 5460, 4465) effectively and economically retard flame in polyester resins and do not significantly affect resin properties. Aroclors improve impact strength, too, and also increase the flexibility of the naturally brittle resin at less cost than plasticizing polyesters.

	POLYESTERS	
formulation	**control**	**modified**
polyester	100	100
styrene	56.5	56.5
antimony oxide	—	15
AROCLOR 5460	—	15
methyl ethyl ketone peroxide (60% in dibutyl phthalate)	3.2	3.2
cobalt naphenate (1% solution)	1.6	1.6
flammability	flammable	SELF-EXTINGUISHING

NEW BOOKLET **gives the facts about "Aroclor Plasticizers" . . . compounding procedures, performance data, property tables, specific formulas. It tells how versatile AROCLORS could be your answer for better compounds at lower cost. Mail the coupon today**

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( ) PL-306, "AROCLOR PLASTICIZERS"

( ) CS-14, "AROCLOR PLASTICIZERS IN EPOXY RESINS"

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STREET.....

CITY.....ZONE.....STATE.....

PHILLIPS 66 MARLEX PLASTICS

BRIEFS

REPORT 61-2

Looking for new markets? Try us!

Although new items made from MARLEX are coming along fast and furiously these days, the market is hardly scratched. A big factor in this happy state of affairs is the ever-increasing number of potential uses for our resins because of constantly improving fabrication techniques and the development of more resin types.

Examples of MARLEX Marketing Information Reports available at our sales offices. To date, some 24 reports have been published.

Overabundance of potential applications has its problems, of course, for those fellows wishing to bring out new MARLEX items. What are the items with a ready market? What are the annual needs for these items . . . distribution . . . long range outlook . . . and so forth? Choosing new items is not easy when tooling and development dollars are involved. Perhaps our Market Research and Commercial Development Group can help when it comes to making these soul-searching decisions. They collect, tabulate, evaluate, and report on potential applications for MARLEX high density polyethylenes, ethylene copolymers, and tailored resins. As it is assembled, this marketing data is put in published reports that are available to all interested. They may be obtained at our district sales offices. If you're in the mood for new ventures . . . why not give us a try!

Thermoforming Shapes Up ...Yes, New Data

In the plastic industry, sheet-forming technology always seems to fall behind the availability of newly developed sheet. MARLEX High Density Polyethylene sheet is no exception. This is tough, durable plastic and forming it properly requires some extra "know-how." Yet, to those who have mastered the art, the outlook is exciting. Already such items are in the works as a 12-foot boat, decorative wall paneling, large re-usable shipping containers, lawn mower parts, and tote trays and boxes of all sizes and shapes.

We're doing our best to broadcast what we have learned from our research on thermoforming. In this vein, we have recently published some technical data on mold design. Discussed are such questions as mold material, cooling channels, contouring, surface finish, shrinkage, and male versus female molds. It's all contained in our Technical Information Bulletin No. 25, "Designing Thermoforming Molds for High Density Polyethylene." We also have a limited number of "MARLEX Sheet Weight and Cost Calculators," a useful slide-rule device for thermoformers. Write now!

Quality Control for Injection Molding

Assuming you're using resins of dependable uniformity and quality (such as MARLEX), there are a number of molding factors affecting the over-all quality and toughness of finished, high density polyethylene pieces. Most important are mold temperature, amount of mold packing, degree and uniformity of stock temperature, and injection speed. What are the effects of these factors? How can they be measured? What optimum values or conditions can be used to control quality during production?

We have just finished a rather exhaustive study on these questions . . . using a fair amount of technical paraphernalia. Interestingly enough, it all boiled down to some very simple and practical quality control measures. No expensive equipment is required . . . and superior molded pieces (often accompanied by appreciable resin savings) are the end results.

For example, both high production rates and maximum toughness are achieved with a low mold temperature. Mold temperatures above 100°F can result in poor quality items. Maintaining the minimum part weight consistent with good appearance is also important to both quality and economy. It is possible, through inadequate control, to pack as much as 17% excessive resin into a part. Brittleness and high part costs are the obvious results.

For those interested in a complete rundown on practical quality control while injection molding high density polyethylene and ethylene copolymers, we've put it all down in Technical Information Bulletin No. 27 . . . just off the presses.

The full scale thermoforming machine at our lab used in studying the problems of mold design. In the foreground, some of the items formed during this research program.

*MARLEX is a trademark for Phillips family of olefin polymers.

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To look back on our long, hard trail of experience serves one indisputable purpose. The reviewing reinforces the accomplishments of the future in the engineering and manufacture of specialized dual worm all-in-one-operation plastics processing equipment with production dimensions consistent with the boldest plans in the plastics field . . . Plans that wear the best known trademarks! WEI appreciates that confidence and will continue to produce equipment engineered to make the most of your future.

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Buffalo Conference Features Plastics Foams

Plastics foams, a subject of intense interest in the plastics industry today, will be discussed extensively at an SPE Regional Technical Conference in Buffalo, N. Y. on October 5, 1961. The Conference is sponsored by the Society's Buffalo Section.

The technical program will feature papers on polypropylene, polyethylene, urethane, epoxy, vinyl, silicone and polystyrene foams and incorporated in each of the four technical sessions will be a concluding panel discussion. Of particular interest in the rigid foam program, according to Chairman William Dunmyer of the Carborundum Co., will be a paper on "Foamable Epoxy Resins" which outlines production of self-expanding, low-density foams at room temperatures.

An outstanding paper on flexible foams will be "The Mechanism of Efficient Production of Fine Cells in the Extrusion of Expanded Polymeric Compositions" in which the vital role of the decomposition characteristics of blowing agents will be discussed. The complete technical program announced by Program Co-Chairmen John P. Valentine of the Durez Plastics Div. of Hooker Chemical Co. and Matthew V. Perry of Lucidol Div. of Wallace & Tiernan Inc. follows.

PLASTICS FOAMS

October 5, 1961, Hotel Lafayette, Buffalo, New York

8:00 a.m.—Registration

9:00 a.m.—Morning Session

Flexible Foams

Moderator: W. D. Todd, B. F. Goodrich Chemical Co.

Progress in Polyethylene Foam
H. W. Tenney, Jr., The Dow Chemical Co.

The Mechanism of Efficient Production of Fine Cells in the Extrusion of Expanded Polymeric Compositions
Ralph H. Hansen, Bell Laboratories, Inc.

The Use of Low Temperature Blowing Agents for Cellular Vinyl Extrusions and for Foamed Vinyl Synthetic Leather
J. H. Hook and J. J. Krajcir, Du Pont Co.

New Dimensions in Cellular Vinyl Processing
Robert J. Meyer, B. F. Goodrich Chemical Co.

Panel Discussion and Question and Answer Period

Rigid Foams

Moderator: Malcolm W. Riley, Materials in Design Engineering

Formulation and Properties of Sorbitol Polyether-Based Rigid Urethane Foams
S. Cear, G. G. Greth and J. E. Wilson, Atlas Powder Co.

Foamable Epoxy Resins
R. E. Burge, A. J. Landua and R. P. Toohy, Shell Chemical Co.

Spray Application of Rigid Urethane Foams
R. Albott and E. J. Robertson, Wyandotte Chemicals Corp.

Dynamic & Static Physical Properties of Expandable Polystyrene
Charles Kienzle, Koppers Co., Inc.

Panel Discussion and Question and Answer Period

12:00—noon—Luncheon

Master of Ceremonies: Tony Nasca, Wallace & Tiernan Co.

Speaker: Dr. Raymond Ewell, Vice Chancellor for Research, University of Buffalo, Buffalo, N. Y.

and a film: Niagara Power Project Story

2:00 p.m.—Afternoon Session

Flexible Foams

Moderator: W. A. McGregor, Mobay Chemical Co.

Formulation of Atmospherically Blown Plastisol Foam
Arnold C. Werner, Naugatuck Chemical Co.

Room Temperature Expanding Silicone Foams
H. L. Vincent, Dow Corning Corp.

The Molding of Flexible Polyurethane Foam by the One-Shot System
F. Dwyer, E. A. Deckert, A. Schultz and H. Stone, Allied Chemical Corp.

Foaming Agents for Polyolefins
Henry Lasman, National Polychemicals Inc.

New Techniques of Polyurethane Foam Preparation
Sigmund Orchon, Carborundum Co.

Panel Discussion and Question and Answer Period

Rigid Foams

Moderator: Robert Kennedy, Dow Chemical Co.

Rigid Foams as Versatile Protection for Componentry Against High G Shock
B. H. Anderson and J. Jacobs, Sandia Corp.

Steel and Foam Stressed Skin Panels
Martin Glickman, U. S. Steel Corp.

Infrared and Dielectric Analysis of Structural Polyurethane Foams
E. B. Murphy and S. C. Nilo, Lincoln Laboratory, Massachusetts Institute of Technology

The High Frequency Expansion of Molded Polystyrene Foam
Richard Bailin, Dynatech Products, Inc.

Panel Discussion and Question and Answer Period

Advance registration fee is $10.00, while registration at the meeting site will be $12.00. Requests for further information and advance registrations should be directed to:

Andrew J. Hammerl
RETEC Registration Chairman
Durez Plastics Division
North Tonawanda, N. Y.

Chairmen of other Committees handling RETEC arrangements include: Honorary RETEC Chairman, Joseph R. Grenier, Protective Closures Co.; Publicity and Printing, Matthew V. Perry; House, Andrew J. Hammerl; Secretary, John P. Valentine and Treasurer, Robert S. Crew, Dow Chemical Co.

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Fomrez Polyether Resins
Fomrez Polyester Resins
Fomrez C-2 Catalyst
Witco 77-86 Coupling Agent

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Polyester Resin—Fomrez No. 50:

A resin noted for its ease of processing, producing flexible foams of uniform, fine cell structure. Foams prepared from this resin find wide application in crash pads, filters, garment interliners, padding, toys, novelties and household items.

Catalyst—Fomrez C-2:

A stabilized stannous octoate used extensively in the preparation of one-shot polyether foams. Fomrez C-2 is completely uniform from batch to batch, producing good foaming qualities and physical characteristics.

Coupling Agent—Witco 77-86

Specifically recommended for use in Witco Fomrez No. 50 foaming formulations. This coupling agent imparts good processing qualities and enhances physical characteristics of foam.

Witco's application laboratories are at your disposal for help in solving any problems connected with production of urethane foams. No obligation. Just contact your nearest Witco Sales Office.

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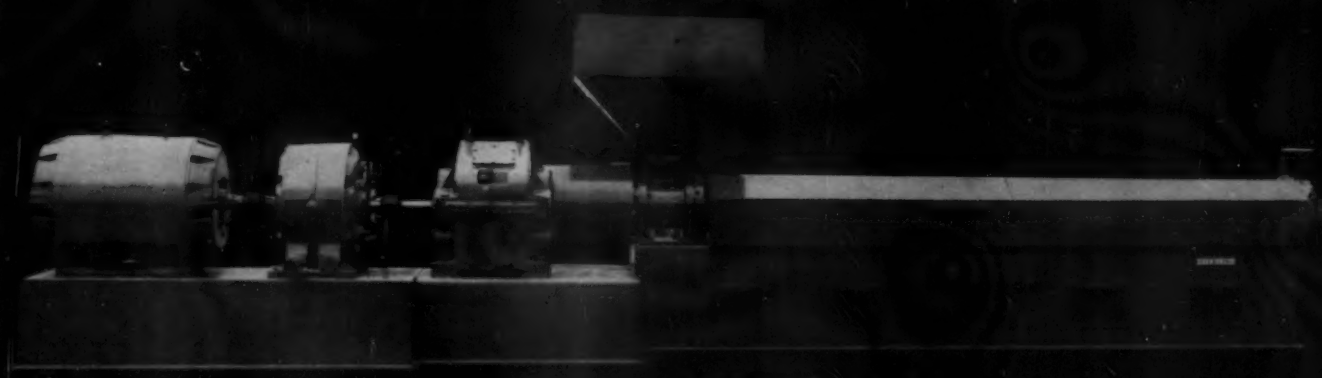

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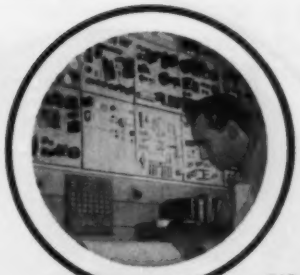
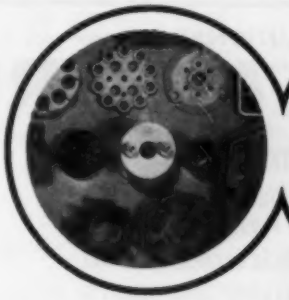


DIE DESIGN

DIE MAKING



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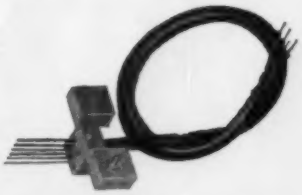

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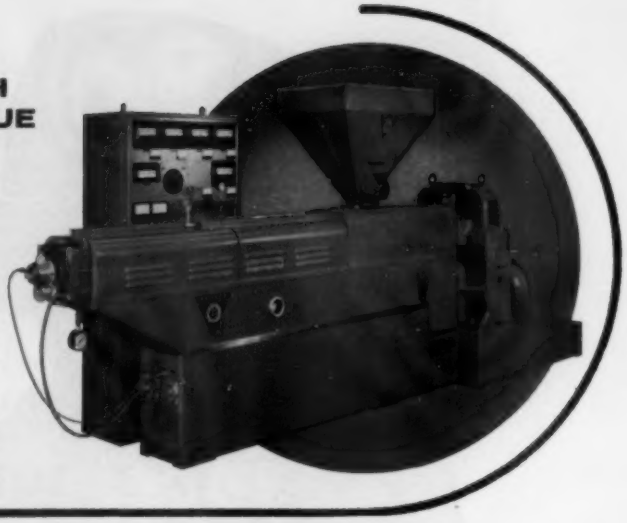

now permit you to select quickly the optimum reduction ratio and screw speed necessary to extrude **either high or low viscosity materials** at maximum horsepower efficiency and highest possible production rate for each extrusion job.

Prodex extruders give you the best possible machine return on your investment of any extruders in the world today. These machines are built vented or non-vented in a complete range from 1¾" to 10".

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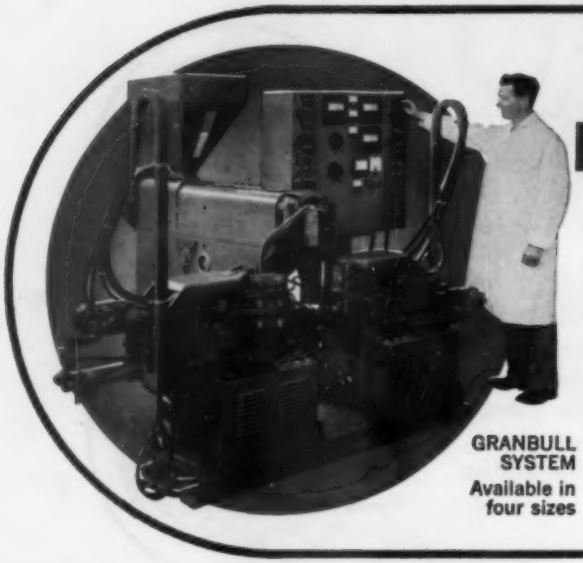

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For small parts—up to 2 gal.—a toggle clamp mechanism is used to develop high pressures and high speed action. A continuous parison flow from a single head feeds up to four mold clamps, resulting in extreme uniformity of parts. The highly streamlined head permits use with all polymers, including rigid PVC.

For large parts—5 to 55 gal.—an accumulator system allows fast extrusion of large parisons, with precise shot metering and uniform temperature throughout the parison prior to blowing.

Prodex blow molders, for maximum output and reliability of operation, are supplied with specially designed, high-performance **Prodex extruders.**

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SPEAKING OF EXTRUSION

Some Comments on Vented Extruder Design

An analysis of fundamental mechanisms and their influence on the design of screws for vented barrel extruders

Very few technical articles on "vented" or "devolatilizing" extrusion have appeared in the literature, despite the fact that this is one of our most important extrusion processes.

Bernhardt, in the most comprehensive paper given to date (1), directed his comments toward the design of vacuum screws for the devolatilizing extrusion of acrylics. Later (2), it was implied that many of these principles can also be applied in the design of screws for "vented barrel" extruders. In this respect, Sackett (3) gave a general treatment of the design and performance of screws for these machines and suggested the advantages of using a valve between the die and the extruder. It was noted, however, that the comments offered were necessarily limited and that no quantitative treatment was given to illustrate the fundamental mechanisms taking place in the process and their design implications. This article offers an analysis of these mechanisms and shows their guiding influence in the design of screws for vented barrel extruders.

General Description

A typical single screw vented barrel extruder is shown in *Figure 1*. The screw for this extruder can be looked upon as two screws in series driven along a common shaft, and is commonly referred to as a two stage screw. Plastic material entering the screw passes through four functional zones: The Feed and Metering Zones, in the first stage; and, the Extraction and Pumping Zones in the second stage.

The Feed Zone picks up the solid polymer being fed from the hopper and conveys it forward as it is being melted. At the end of this zone, the polymer exists as a viscous melt. This zone of the screw has a deep channel of high volumetric conveying capacity.

The Metering Zone throttles or "meters" the flow from the feed zone and governs the output rate of the extruder. This section has the smallest channel depth of any of the four zones and, therefore, the smallest drag flow capacity.

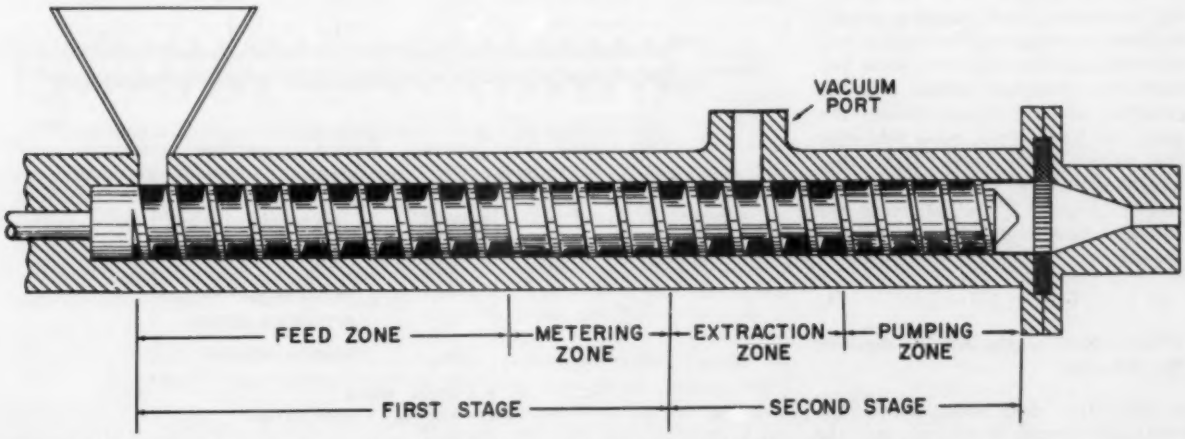


Figure 1. Vented barrel extruder. Design permits removal of volatiles from thermoplastics

The Extraction Zone serves as a disengaging section where the actual separation of the volatiles from the polymer takes place. The channel depth in this zone is several times that of the metering section and, therefore, this section has a conveying capacity several times that of the metering section. As a result, the screw channel in this section is never filled to capacity. The molten polymer builds up on the pushing flights of the screw and fills only the rear portion of the channel.

The vent or vacuum port in the barrel is located to register with the extraction section of the screw and, in operation, vacuum is applied to the unfilled portion of the screw channel through this port. The polymer containing volatiles will foam as it enters the vacuum of the extraction section. However, if the vent port is located sufficiently far downstream, the foam will have subsided by the time the polymer reaches the vent. Consequently, the volatiles can be pulled through the vacuum port without polymer carry over.

The Pumping Zone picks up the devolatilized polymer and develops the pressure required to push the polymer through the die of the extruder. It should have a higher drag flow capacity than that of the metering section to compensate for the pressure flow caused by the back pressure of the die. It, therefore, has a channel depth slightly greater than that of the metering zone, but not as deep as the extraction zone.

Comments on Design

After having reviewed the functions of the various zones of the screw, a number of questions immediately come to mind. For example, one might ask how deep should the channel be in the metering, extraction, and pumping zones? Is there an optimum pump ratio, i.e., an optimum channel depth ratio between the pumping section and the metering section? Where should the vent port be located? What role does the valve play? These and other questions may be answered by referring to *Figure 2* and applying the extruder flow equations to each of the stages.

$$Q_{net} = Q_d - Q_p \qquad (1)$$

where Q_{net} = the total output of the extruder

Q_d = the **drag flow** down the channel produced by the shear on the fluid induced by the relative motion between the screw and the barrel.

Q_p = the **pressure flow**, the backward flow down the channel length produced by the die back pressure.

For a metering type screw, the equations which describe the drag and pressure flows in the sections having both constant pitch and constant channel depth, are:

$$Q_d = F_d \cdot \frac{\pi^2 D^2 h \sin\phi \cos\phi}{2} \cdot N \qquad (2)$$

$$Q_p = F_p \cdot \frac{\pi D h^3 \sin^2\phi}{12L} \cdot \frac{\Delta P}{u} \qquad (3)$$

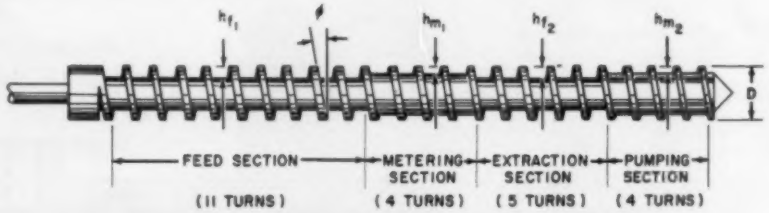
where F_d and F_p are the drag and pressure flow shape factors; D, the extruder diameter; h, the channel depth; ϕ, the helix angle; L, the axial length of the section; N, the screw speed; u, the melt viscosity; and, ΔP, the pressure rise in the screw or the drop across the die system.

First Stage Screw

Operation of the first stage screw is similar to that of any conventional single screw machine except that this screw does not see back pressure since it discharges into the vacuum of the extraction section. Consequently, there is no back pressure flow and the output from this stage, and therefore, the extruder, is equal to the drag flow capacity of the metering section. It is obvious then, from equations (1) and (2), that the channel depth in this section is selected to give the desired output, consistent with product quality. Also, due to the absence of back pressure, it is likely that its depth will be somewhat shallower than that normally used in conventional machines, to avoid surging and achieve satisfactory mixing and conversion.

In a 24:1 L/D machine, it is customary to make the length of the first stage approximately 15 L/D's; long enough to properly convert the material before it reaches the vent. The best metering section length will depend on the material to be extruded; but a length of 4 L/D's has worked well for a variety of materials.

The design of the first stage screw is the most difficult and critical part of the whole design problem. A detailed discussion of this phase of the design is outside the scope of this paper. However, it is stressed that the absence of back pressure intensifies the design problem since the metering section is vulnerable to being "over-driven" by the feed section. This is to be avoided since the design of the second stage screw assumes that the output from the first stage is controlled by its metering section. If the pumping capacity of the feed section is over-designed too much, the extruder may become unbalanced and material will go up the vent. It would appear reasonable to design the feed section with a capacity slightly in excess of that of the metering section. In this way, the metering section will run full, the output will be predictable, and the extruder performance amenable to analysis. Also, any pulsations which may originate in the feed section are less likely to pass undampened through the metering section.



CHANNEL DEPTH	SECTION
h_{f_1}	FEED SECTION
h_{m_1}	METERING SECTION
h_{f_2}	EXTRACTION SECTION
h_{m_2}	PUMPING SECTION

ϕ = HELIX ANGLE

$X = h_{m_2}/h_{m_1}$ = PUMP RATIO

Figure 2. Screw design for 24:1 L/D vented barrel extruder

Second Stage Screw

It has been said (1) that the channel depth in the extraction section should be 4 times greater than that of the metering section. Actually, in practice this ratio has not been found to be critical. Ratios in the 3 to 6 range have worked satisfactorily, with the higher ratios being preferred to minimize radial pressure development in this section. This pressure arises from the normal stress effect and is manifested by a swelling of the polymer as it is being sheared in this section. This is to be avoided as much as possible since the greater the swell, the greater the tendency for the material to be "clipped off" and held up at the vent. Also, the deeper channel would result in a greater foam handling capacity, more transverse type flow, and consequently, greater extraction efficiency, since the rate of area exposure for evaporation of volatiles would be greater. These are the reasons for keeping the channel depth constant in this section and making an abrupt step up to the pump.

It is interesting to note that, if one takes the drag flow shape factors into account (4), there is less than 10% difference in the calculated drag flow capacities of the extraction section, over a 2.5:1 to 4:1 channel depth ratio range.

The length of the extraction section will depend on the amount of volatiles to be removed and the type and state of the resin being extruded. On a 24:1 L/D machine, extraction lengths of 3 to 5½ L/D's have been used . . . the latter on difficult extraction applications where it is necessary to expose the polymer to the vacuum for a longer time. As stated earlier, the vacuum port should be located sufficiently far downstream in the extraction section to allow time for the foam to subside before the polymer reaches the vent. However, the vent should not be located too close to the pumping section as this would cause a pluggage of the vent at the slightest back flooding of the extraction section. A position 1/2 to 2/3rds downstream in this section has been found to be satisfactory in many applications.

The channel depth of the pumping section will depend, among other things, on that of the metering section. A material balance on the whole screw may be written as follows:

$$Qnet = Qd_1 = Qd_2 - Qp_2 \quad (4)$$

where the subscripts 1 and 2 refer to the metering and pumping sections of the first and second stages, respectively. Thus, the drag flow of the pumping section must be greater than that of the metering section by the amount of pressure flow which takes place. Equations (2) and (3) may be simplified and substituted into equation (4) to give:

$$K_1hm_1N = K_1hm_2N - K_2hm_2^3 \cdot \frac{\Delta P}{u_2} \quad (5)$$

Equation (5) shows that the amount of pressure flow depends on the viscosity of the polymer in the pump section, its channel depth, and the amount of die back pressure. Since the latter will vary widely, depending on the die and material being extruded, it might be well to choose or at least know the channel depth or pump ratio which will have the greatest pressure developing capacity. This may be determined from equation (5). If we call x the pump ratio, then $hm_2 = x \cdot hm_1$. Substituting this in equation (5) and solving for ΔP, we have:

$$\Delta P = \frac{u_2K_2}{hm_1^2} \cdot \frac{x-1}{x^3} \quad (6)$$

If we assume the polymer to be newtonian, i.e., a constant viscosity, and then differentiate equation (6) with respect to x and set the derivative equal to zero, we find that the pump ratio having the greatest pressure developing capacity is 1.5:1. The ratio will be higher if the non-newtonian viscosity of the polymer is taken into account. In the case of both a 0.2 and a 5.0 melt index linear polyethylene, maximum pressure development was calculated to occur at a 1.75:1 pump ratio. This ratio should be looked upon as the upper limit for these materials rather than the recommended value. The best ratio will depend on the application one has in mind. If the extruder is to be used as a devolatilizer and color compounder, the higher pump ratio would likely be more desirable since more transverse and back channel mixing would occur. On the other hand, if precision extrusion is required, lower ratios, perhaps in the order of 1.25:1, may prove more beneficial as these would tend to have smaller variations in output rate.

The pumping section should be made long enough to develop sufficient pressure to pump the polymer through the die and achieve satisfactory mixing. On a 24:1 L/D machine, a pump length of 4 L/D's has worked satisfactorily for many materials.

The Role of the Valve

In practice, the net conveying capacity of the pumping section should be made to equal that of the metering section so that material will not flood the extraction zone and back up through the vent. This also avoids starving of the pumping section, which otherwise would result in a loss in dampening action and possibly, surging, if any pulsations develop in the preceding sections. We know from the foregoing that this balance is difficult, if not impossible, to bring about by screw design alone. On the other hand, this balance is easily achieved by using a valve at the head of the extruder to adjust the back pressure. The screw can then be designed for the highest expected die pressure, and when low resistance dies are used, the valve can be adjusted to bring the pressure up to the design or balancing level.

As stated earlier, there have been very few technical articles on this subject and it is hoped that additional papers will be offered. Of interest would be discussions of the advantages of valving the metering section, the design of the vent port insert, techniques to improve extraction efficiency, and the rate precision achievable in vented extrusion. It is the author's intention to offer, in a later issue, some comments on the scale-up of vented extruders.

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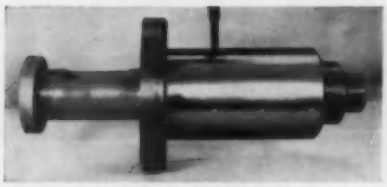

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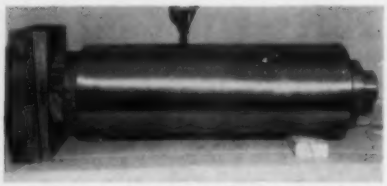

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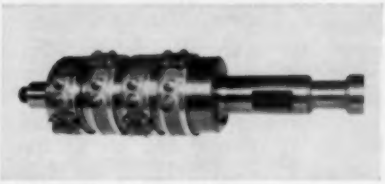

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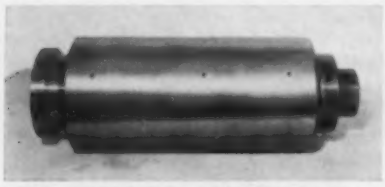

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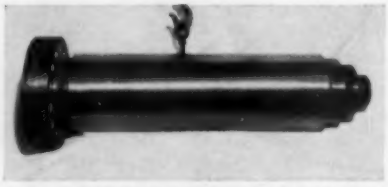

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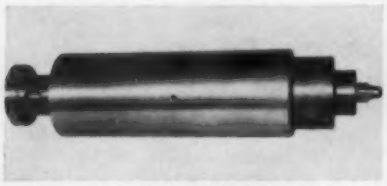

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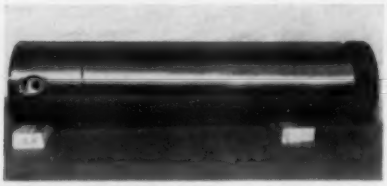

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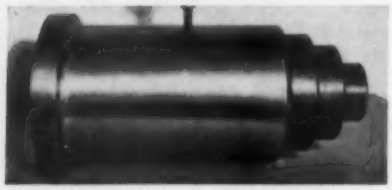

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MOLDING CYCLES

Molding High Density Polyethylene in Large Boxes, Trays and Lids

Difficulties in molding high density polyethylene can be overcome by using special techniques. Design, gating, cooling provisions and type of molding machine are all variables which should be adjusted to obtain better results

During the past three or four years, the plastics industry has been using more and more high density polyethylene. In the injection molding field most items have been rather small and of symmetrical shape. Some molders claimed that high density polyethylene can be molded only into round bowl shaped items. After observing some of the results obtained with the other shapes, it is understandable why they feel this way.

Other molders are not experiencing this trouble. By proper design of the part, proper gating, proper and adequate cooling provisions in the mold and the right type of injection molding machine, high density polyethylene is being molded into large rectangular and flat items. The aforementioned variables will be appraised below.

Proper Part Design

Studies of molded items show that some concepts of part design which were used for other materials are unsatisfactory for high density polyethylene. For example, to increase rigidity in a part the walls have often been tapered from thin at the bottom to thicker at the edge. When using high density polyethylene, a slightly thicker wall in the gate area with uniform wall thickness throughout the part or a slight thinning toward the edges has proven to be best. A thicker section in the gate area improves the ease of fill and reduces orientation that is conducive to brittleness and distortion.

If additional rigidity is required, it is preferable to change the geometry of the part rather than the wall thickness. *Figure 1* shows some designs which have been quite sucessful. The double stepped edge is very effective and can be used quite well with an item that has a lid. These steps or changes in plane do not have to be very large; even a step no greater than the wall thickness of the part is very helpful. These steps, in addition to providing rigidity, also help to disturb the flow of material along the cavity and to spread out

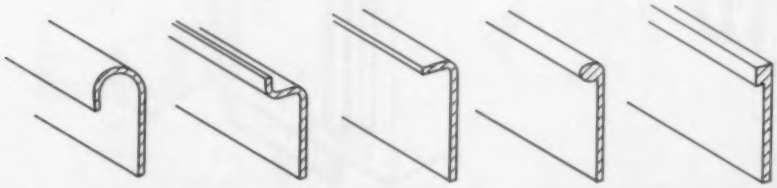

Figure 1. Lip design features which have proved successful for imparting additional rigidity

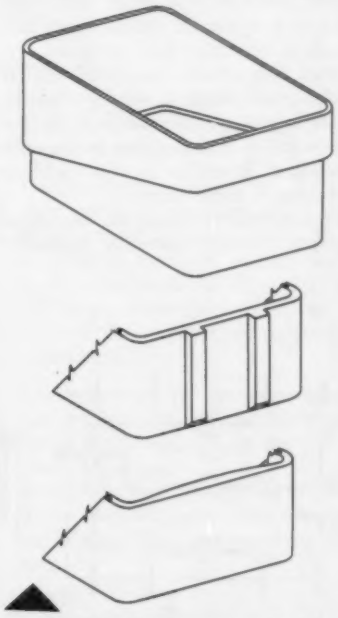

Figure 2. Features that have decreased warpage tendencies of container side walls. The sloping step has been effective

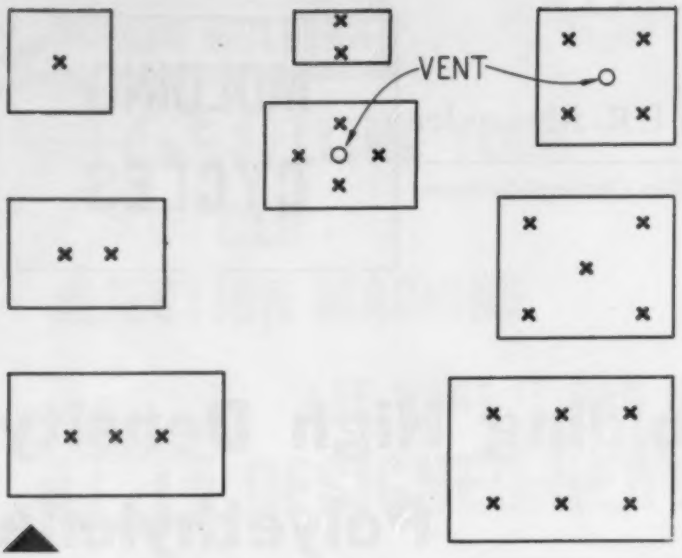

Figure 3. Gating patterns normally used for rectangular boxes and trays

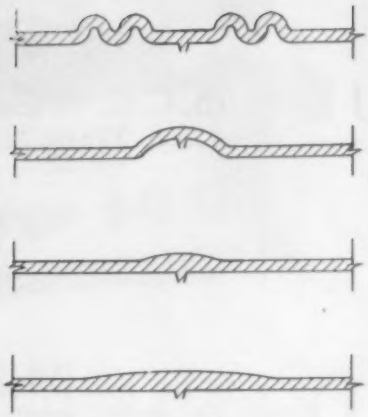

Figure 4. Recommended gate designs for polyolefin items used to reduce gate brittleness problems

the advancing front so that the cavity is filled more uniformly. *Figure 2* shows a box with a sloping step around the part which was very effective.

Gating

At the present time, this is an art and hardly a science. A pattern seems to be developing which may lead to a method for computing the number of gates required in a part. For example, there is one mold with 144 gates, yet a similar almost exact duplicate of this part has 32 gates. In another case about a 4 pound item is single gated while a similar item is 5 gated. It was observed that the injection speed of a machine is the only significant difference in the molding operation in these cases.

Figure 3 shows some of the more common gating patterns normally used for rectangular boxes, trays, etc. The pattern picked depends upon part size, wall thickness, geometry of part and type of machine being used. Past experience is also a very important consideration in determining a gating pattern. *Figure 4* shows some of the designs that are commonly used in the gate area. Any of these designs are effective in reducing the gate brittleness problems sometimes encountered.

Cooling

This factor cannot be stressed too much. Not only do we want a cool mold, but we want one of uniform temperature. Most molders have had very few problems with molds that can be run during production at uniform surface temperatures between 65°F to 100°F. Above 100°F the impact strength of the molded parts drops off rather sharply. At times it may be necessary to run some areas of a mold warmer than others, but usually a uniform temperature is best. A variation of 10°F to 15°F between different parts of a mold has often caused warpage problems. They have usually been eliminated by additional water channels or by varying the temperature of the cooling water to different parts of the mold. In either case the objective is to maintain a uniform mold temperature during production which results in a uniform cooling of the part.

Figures 5 and 6 show some typical methods for cooling the core of a rectangular item. In either case individual lines or groups of lines may have warmer water feeding them to maintain a uniform mold temperature or in some cases it has been desirable to warm certain areas to assist flow or to prevent warpage. *Figure 7* shows a typical water channel layout for a rectangular cavity. In all cases it is best to have separate "in" and "out" connections for each water channel. After the mold has been

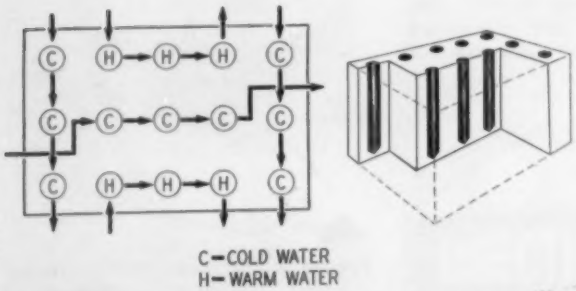

Figure 5. Water channeling in mold core for a rectangular item

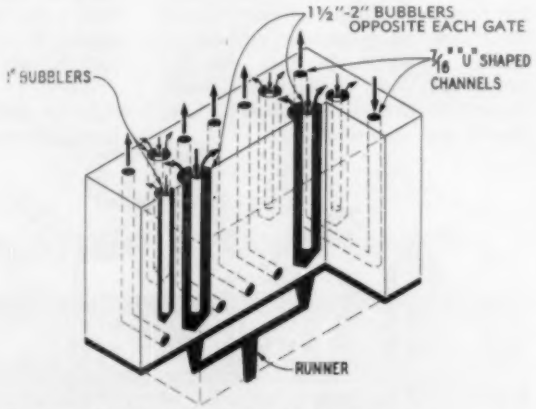

Figure 6. Water channeling incore

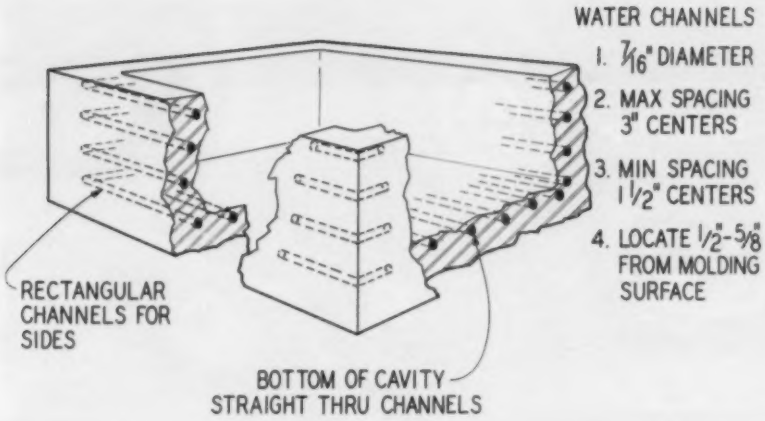

Figure 7. Mold cavity water channels for die temperature control

run and lined out, channels using the same temperature cooling water can be looped together outside of the mold.

In the past, flat items have always been a problem in high density polyethylene. Recently parts approximately 16" x 16" and 16" x 14" have been molded very satisfactorily using a tab gate along one edge of the part. In both cases the parts were designed with a slight gradual curvature which did not exceed ½" from a flat plane. In both cases the parts reproduced the cavity almost perfectly. *Figure 8* shows the general procedure used. Several smaller parts are being produced using this same method. In a few cases it has been necessary to use warmer water in the cooling lines furthest from the gate to aid in filling the mold and to balance the heat removal. In 3 or 4 cases it was necessary to slightly increase the part thickness in the gate area tapering the thickened area back to the normal wall within an inch or so of the edges of the gates. It is very important and necessary to have the polymer enter the cavity in such a way that it impinges on the opposite wall of the cavity or some other obstruction such as a core pin. Jetting directly into the cavity can cause flow mark problems and can actually weaken the part.

Molding Machine Considerations

Everyone is familiar with the fact that a mold will run better on some machines than it will on others even though the machines are rated the same and may even be of the same make and model. In such cases the machine doing the best job is the one with the largest and most efficient heating cylinder and the one with the fastest injection speed. The thinner the piece and/or the further the polymer has to travel in the cavity the faster the fill time required. Many molding problems have been simply solved by reducing the fill time from 8 or 9 seconds to 2 or 3 seconds.

Recently there was a job involving a single cavity, small, lightweight, 0.020" thick wall container. The mold could not be filled on a 12 oz. machine using an extra booster pump. By moving to a much faster injection speed machine the part filled easily in about ⅛ of a second. In another case, a mold was finally filled in 8 seconds using all possible pressure and extremely high polymer temperature. However, the part was too distorted and brittle to be used. The mold was moved to a machine with a pre-plasticizer and much faster injection speed. The mold was filled easily in 2½ seconds with a 200°F lower polymer temperature and the parts reproduced the cavity beautifully and were very tough and serviceable. The really successful molding of large rectangular and flat items being produced to date have been done on new high injection speed machines or on machines that have had extra booster pumps or hydraulic accumulators added. Additional gates in a mold have sometimes been helpful. Raising polymer temperature has helped in a few isolated cases, but above 600°F the polymer degrades and parts so produced are usually junked.

Summary

Better results in injection molding have been obtained by the use of the following techniques:

1. Faster injection speeds.
2. Tab gating of flat parts.
3. Employment of adequate cooling in order to maintain uniform mold surface temperatures below 100°F.

For large rectangular parts other factors, which are listed below, should be considered.

1. Reinforcement of the gate areas.
2. Geometrical shape should be taken advantage of in order to reduce distortion.
3. Gating an item in such a way so as to permit rapid uniform fill, considering the geometry of the part.

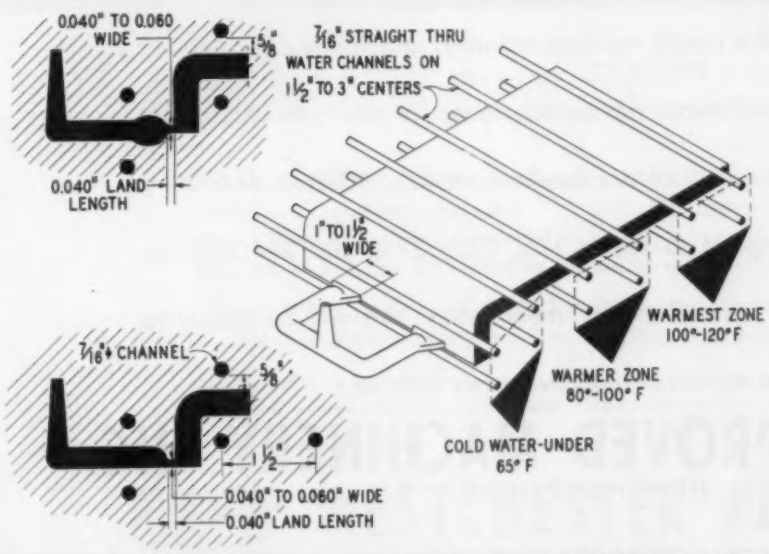

Figure 8. Tab gating for a flat item. Tab gates are along one edge of the part

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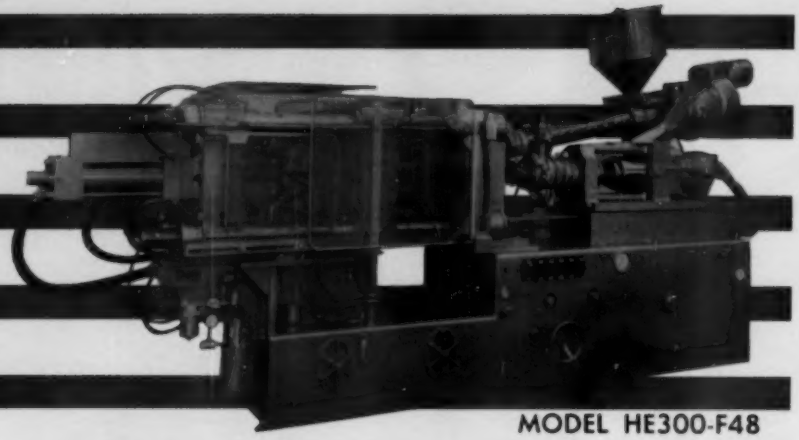

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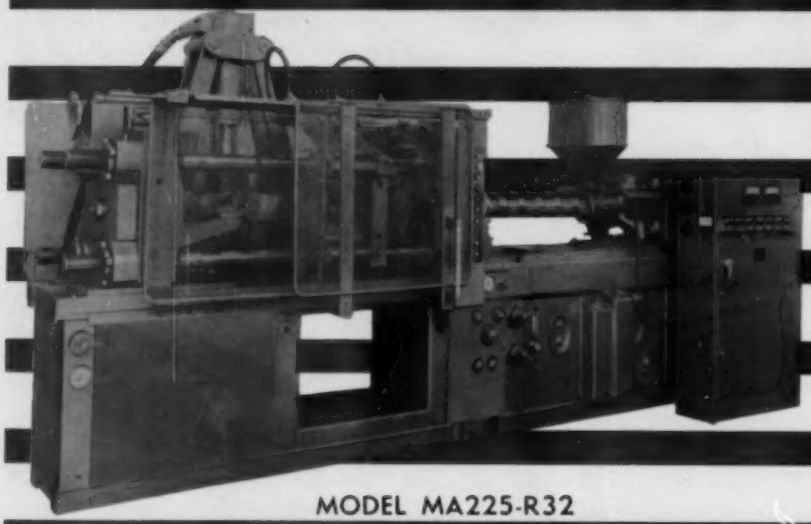

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REINFORCED PLASTICS

Reinforced Plastic Aviation Gas Turbine Compressor Housing

The development of a glass-reinforced polyester molded compressor housing for an aviation gas turbine has enabled reinforced plastics to enter a field formerly held exclusively by metals. While plastics have been extensively used in air frames, i.e., radomes, wing tips, leading edges; never before have glass-reinforced plastics been used as a major structural component in the power plant of a jet engine

The compressor of aviation gas turbines is used to compress air and introduce it into the burners of the engine. Each compressor stage consists of one set of stationary and movable blades. Surrounding these blades is the compressor housing which presently consists of a four-piece magnesium cylinder. The cylinder has a series of eleven radial grooves from front to back, into which the stationary blade assemblies are fastened. These magnesium housings are light in weight, durable, and have performed exceptionally well in service.

The jet engines tested are used in naval aircraft. It is understandable that naval equipment, in general, must be highly resistant to the corrosive effect of salt water. Indeed, corrosion of metal compressor housings, particularly magnesium, has been a problem for some time; and to eliminate this disadvantage, it was proposed that a compressor housing be fabricated from glass-reinforced plastics. The advantages of using a plastic material for a military aviation gas turbine compressor housing become obvious. Such a housing would be extremely lightweight compared to aluminum, steel, or titanium. Very low maintenance cost would result because of the lack of corrosion. Reinforced plastics, in general, have excellent ballistic impact resistance. The plastic housings have low thermal expansion and low thermal conductivity. What little machining may be necessary for a plastic housing can be done conveniently and cheaply. Plastics can be made either self-extinguishing or very slow burning, thereby resulting in greater safety for the aircraft. In time of national emergency, the use of plastic compressor housings becomes even more attractive because critical materials such as magnesium and titanium are not required and the housings can be produced by a branch of industry not likely to be overloaded with military production.

To determine the feasibility of using reinforced plastics in the compressor housings of jet engines, a four-point program was decided upon. This program consisted of (1) materials development, (2) mold design, (3) fabrication of a reinforced plastic compressor housing, and (4) engine tests of molded plastic compressor housings.

By virtue of extensive work in laminating resins, the materials investigated in the program were limited to an exacting investigation of a high temperature phenolic laminate, R-2, and a high temperature polyester laminate, R-5.

Materials Development

A program to test certain critical physical properties of the laminates was devised. To prepare specimens for this evaluation program, the resins were combined with Style 181 glass cloth with a 136 surface treatment. Laminates were molded to be ⅛" thick, except wherein specified differently and were made from twelve plies of resin-treated glass cloth. The glass content in the finished laminates was about 60% by weight.

Tensile Tests—When an aviation gas turbine compressor of the J-34 class is in operation, the pressure on the housing can be as much as 60 psi. This pressure results in tensile loadings on the circumference of the barrel-like housing. Therefore, it was important to determine the tensile behavior of reinforced plastics at both high and low temperatures and after exposure to water and to certain lubricating oils common to jet engines.

Room temperature tensile tests were made according to ASTM-D-229-49. Specimens were 1" wide, 9" long, and ⅛" thick. The high temperature tests were made in an oven placed around the samples mounted in a testing machine. Low temperature tensile tests were made in an insulated cylinder which was cooled with liquid hydrogen and which completely surrounded the samples and the grips. Tensile tests were also made on samples which had been immersed for one week in water and MIL-L-7808 and MIL-0-6081 oils.

The tensile properties of both R-2 and R-5 laminates were very good at elevated temperature and compared favorably with both aluminum and magnesium alloys. *Figure 1* is a graph of the tensile strength of R-2 and R-5 versus temperature. For comparison, the properties of the presently used magnesium casting alloy, EZ33-T5 and aluminum casting alloy, 355-T6, are shown. Exposure to water or lubricating oils has no significant effect on tensile strength.

Thermal Properties—The thermal expansion of the laminates was determined on specimens ⅛" x ¼" x 4" long. The measurements were made with a Tuckerman Optical Strain Gauge between −85°F and 500°F. The thermal conductivity of the laminates was measured according to ASTM C-177. Specimens were 9" x 9" x ½" thick. The flame tests were run as required in Specification MIL M-14E.

The thermal properties of the laminates are shown in *Table 1*. Both laminates have an "inflection temperature" wherein the thermal expansion changes rapidly from a high value to a lower one.

Stress Rupture Tests—All creep data was obtained with a spring-loaded creep machine using specimens ⅛" x 1" x 9" long. Tests at temperatures other than ambient were made with the same thermal equipment as used in the tensile tests. Creep rupture properties for R-2 and R-5 laminates were determined after water immersion and after exposure to the two lubricating oils described above. These data are plotted graphically using a new technique of representing creep data. In this technique, the grand average of all creep-rupture data is connected with a straight line with the tensile strength plotted at a time of .1 hours (1).

Figure 2 shows a comparison of tensile strength as a function of temperature for the laminates and the alloys now used. At 500°F, both R-2 and R-5 are superior to magnesium and aluminum.

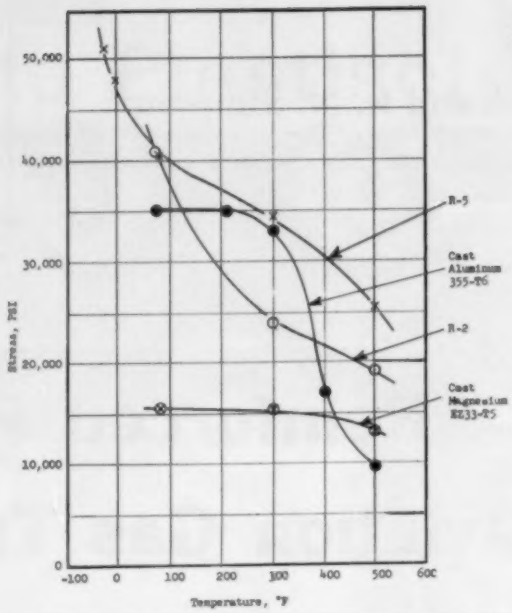

Figure 1. Tensile strength of R-2 and R-5 laminates and aircraft alloys versus temperature, tested at temperature after 200 hours aging at test temperature

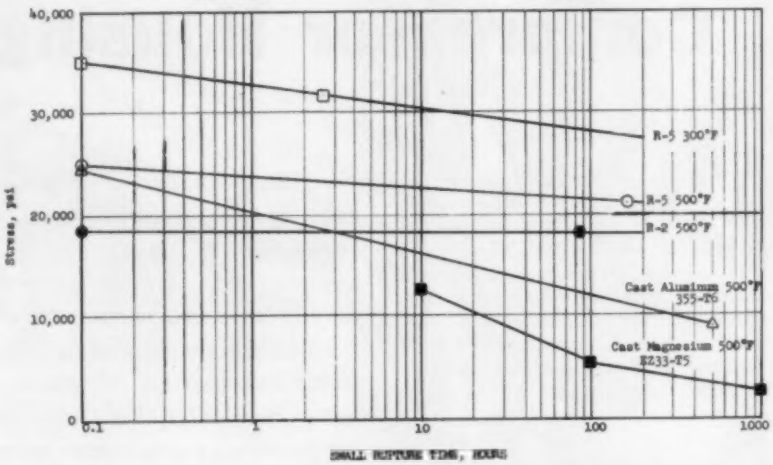

Figure 2. Creep rupture curves for laminates and aircraft alloys at elevated temperatures.

Table 1. Thermal Properties of Laminates of R-2 and R-5

Property	Resin	Temperature (°F)	Value
Thermal Conductivity	R-5	75 to 500	1.75 BTU/hr/ft²/°F/in.
Thermal Expansion	R-2	−85 to 80	6.39×10^{-6} in/in/°F
		80 to 200	6.90×10^{-6} in/in/°F
		200 to 500	3.01×10^{-6} in/in/°F
	R-5	−85 to 85	4.06×10^{-6} in/in/°F
		85 to 500	3.82×10^{-6} in/in/°F
Flame Resistance	R-5		130 seconds to ignite 238 seconds burning

Creep-rupture data for R-5 laminates are shown in *Figure 3* plotted as a function of temperature. Note the parallelism of the lines and also that at −20°F the laminates are almost twice as strong as at 500°F.

Ballistic Impact Tests—Since one of the prime interests in obtaining a glass-reinforced plastic housing was the housing's resistance to ballistic impact by projectiles or broken compressor blades, it was necessary to determine the ballistic impact resistance of the laminates. It was obvious that both Charpy and Izod impact tests would be unsuitable and, therefore, a ballistics-type impact test was devised in which a .38 caliber pistol was fired at panels from a distance of 9.5 feet. The cartridges consisted of 146.5 grain lead bullets prepared with a 3 grain powder charge. The laminates were made in 4" x 4" panels with thicknesses of ⅛, ¼, ⅜, and ½". A fixture was designed to hold the panels at 90° and 45° to the path of the bullets.

Figure 4 is a plane view of the laminates which were held 90° to the path of the bullet, and *Figure 5* is the side view of the laminates held 90° and 45° to the projectile. Note that the bullet penetrated only the ⅛" laminates but that extensive delamination occurred with all samples.

The impact energy absorbed by those panels not penetrated was calculated to be 213 foot-pounds. The approximate impact energy or kinetic energy of a compressor blade leaving the rotor of a jet engine (J-34) was estimated to be 2300 foot-pounds. It is impossible to predict whether or not a compressor blade would penetrate the plastic housing because of the numerous differences which exist between this test and the actual loss of a compressor blade during engine operation. To determine the exact laminate thickness needed to stop a free compressor blade, a destructive test using actual blades, rotor, and a housing would be required.

Material Choice—The foregoing tests indicated that many of the physical properties of the R-5 laminate were superior to that of the phenolic laminate, R-2. Since the R-5 resin was much softer and easily draped, complex lay-ups could be easily made. This, in combination with the material's superior physical properties, resulted in a decision to eliminate the phenolic R-2 and to fabricate the glass-reinforced compressor housing from the polyester material, R-5.

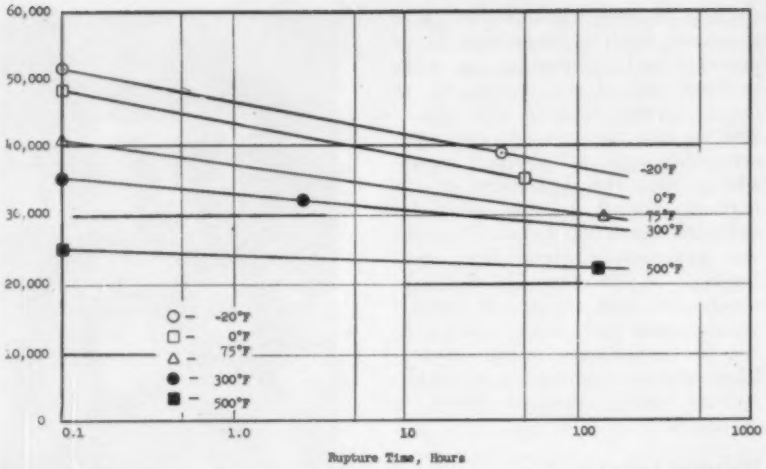

Figure 3. Creep rupture strengths of R-5 laminates at −20, 0, 75, 300, and 500°F

Mold Design

In a series of conferences with appropriate engine designers, it was found desirable to modify the shape of the existing housing consistent with the nature of the R-5 laminate and the requirements of plastic molding techniques. The four sections of the existing metal compressor housing were redesigned to result in two matching identical parts. Various bosses and mounting shoulders were modified or eliminated. The air bleed manifold section was a special problem. This manifold removes from the rest of the compressor small amounts of compressed air to be used for cabin pressurization and motive power for certain instruments and devices. Since the

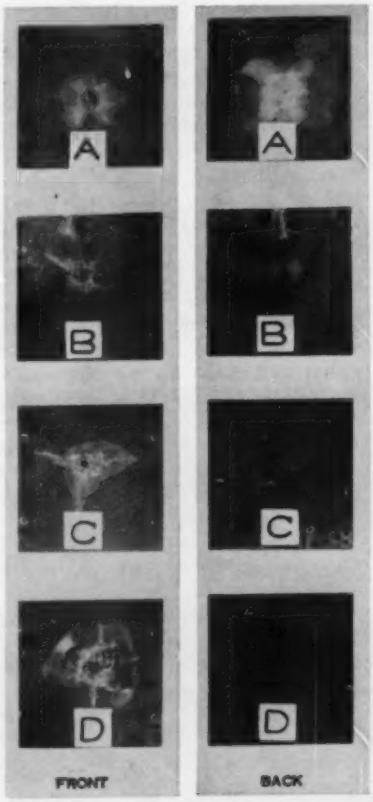

Figure 4. Plane view of R-5 panels after impact by 38 cal. projectile. Panels held 90° to path of projectile. Panel thickness A—⅛", B—¼", C—⅜", D—½"

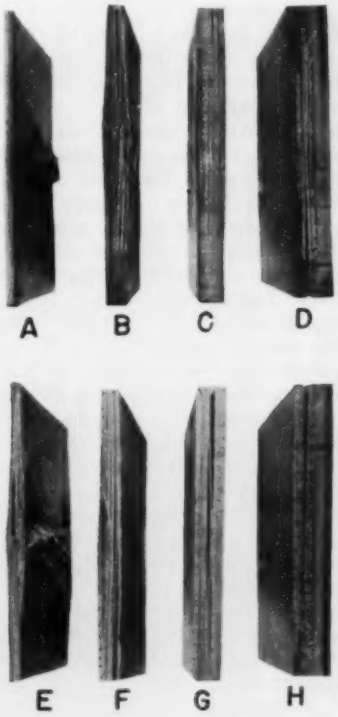

Figure 5. Edge view of R-5 panels after impact by 38 cal. projectile. Panels A-D held 90° to path of projectile, E-H held 45°

space is annular, it was obvious that a second, small molding, had to be provided and fastened to the main molding. All of the dimensions of the compressor housing were modified to take into consideration, the resin shrinkage and thermal expansion so that the dimensions of the finished molded housing could be held within ± 0.005 inches. The mold was manufactured from large steel forgings of Hardtem D and fabricated into male and female sections with massive end pieces which contain the end flanges of the housing. The mold was installed in a 400-ton upward acting press as shown in *Figure 6*.

Housing Fabrication

Impregnation of the Reinforcement—It had been decided to utilize a combination of glass cloth and glass mat reinforcement in the plastic compressor housing. The glass cloth used was 181-136 and the glass mat used was both 3 ounce and 1½ ounce. The cloth and the mat were impregnated with a 55% resin-acetone solution in vertical treating towers resulting in an impregnated molding material with a resin content of 45%. The shelf-life of this material was found to be in excess of eight months.

Construction of Templates—The housing had been designed to be ⅜" thick. Since the diameter of the housing was so large, the dimensions of the innermost layers of the laminate would be smaller than the dimensions of the outermost layers. Accordingly, six templates were designed to insure perfectly shaped glass reinforcements. These templates were basically similar in shape, but each one was slightly larger than the next. The templates were also designed to provide more material at the inlet and outlet ends of the compressor housing wherein the housings suddenly increased in diameter.

Placement of the Reinforcements—Specially cut elliptical sections of impregnated mat were placed into the cavities which form projecting bosses on the outlet end of the compressor housing. These bosses are used to mount ancillary equipment on the housing.

Extra mat strips were also applied at the flange area, since the flanges were thicker than the body of the compressor housing.

Projections on the male sections of the mold form the stator vane slots of the molding. These sections had varying cross sections and required the precise placements of carefully shaped 3 ounce mat in each of the eleven slots. This operation is shown in *Figure 7* which also shows the boss reinforcements.

Figure 6. Mold for reinforced plastic compressor housing mold installed in 400 ton press

The main lay-up consisted of eighteen plies of cloth made of six three-ply layers cut with each of the six main templates. These plies were stapled together at the edges to prevent misalignment during molding. The plies were assembled on the specially designed lay-up jig shown in *Figure 8*.

Molding—The completed assembled lay-up was placed into the female portion of the mold which was maintained at room temperature. The press was closed slowly, and as the press closed, the temperature was increased to 70°C. After the press was closed, the pressure was adjusted to 215 psi on the 800 square inch molding area. These conditions were maintained for 1½ hours, during which time the excessive resin was expelled from the mold. The temperature was increased to 120°C and the pressure was increased to 1000 psi for two hours, at which time the press was opened and the molding removed.

Internal Bleed Manifold Insert—The internal bleed manifold insert was a semi-circular part which was vacuum bag molded on a wooden form. This section was then cut in half and bonded into the inside of the completed molded housing as shown in *Figure 9*.

Finishing the Molding—All excess flash was trimmed from the flanges and the molding was clamped to holding jigs and placed into an oven at 80°C for two hours. The temperature was then increased at 10°C per hour to 200°C to complete the cure. The molding was cooled and painted with Cat-a-lac primer 8044 and Cat-a-lac paint 8126.

Engine Tests

Hydrostatic Tests—The molded housings were subjected to a hydrostatic qualifying test, to determine how well they would withstand the air pressures encountered in service. The two sets of moldings were installed into a test fixture, using long through-bolts to fasten the top and bottom gasketed pressure plates to the housing. Water at 60 psi was maintained in the housing for several minutes while pressure gauges were observed. The housing did not distort and no leaks were observed.

Engine Test—The necessary stator blades, rotor, and auxiliary equipment were installed in the plastic compressor housing. The housing

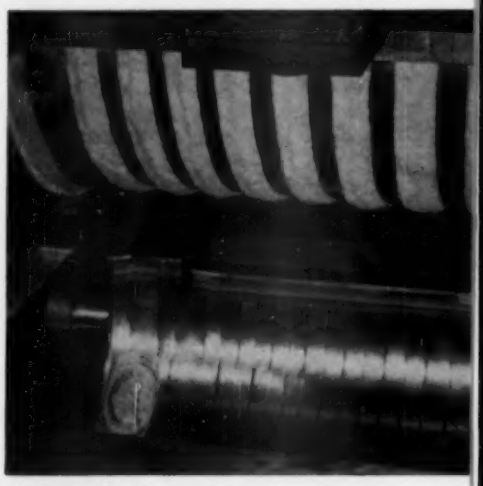

Figure 7. Placement of mat reinforcement which forms the stator vane slots

Figure 8. Assembled lay-up on lay-up jig

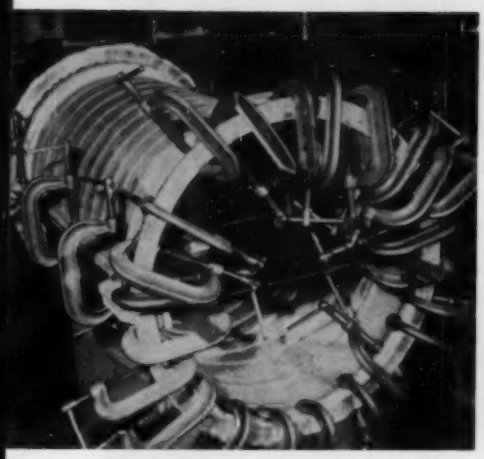

Figure 9. Bonding internal bleed manifold insert into housing

was given a 150-hour endurance test in jet engine test cells at the Westinghouse Plant in Kansas City as shown in *Figure 10*. The first part of the jet engine tests provided for an engine check-out and a preliminary examination for blade tip rub on the housing. This preliminary examination was as follows:

1. The engine was started and run at 1000 rpm for one minute.
2. The engine was accelerated to 12,500 rpm in 500 rpm increments, holding the speed for one minute at each increment.
3. The engine was decelerated to 4000 rpm in 500 rpm increments, holding for one minute at each increment.
4. The engine was stopped and examined for blade rubs on the housing.
5. The engine was started again and operated at 400 rpm for three minutes, then accelerated to 12,500 rpm within 12 seconds. The engine was run at 12,500 rpm for three minutes and stopped to listen for blade rubs again.
6. The 150-hour endurance test was then made according to Specification MIL–E–5009–A, which test consisted of a multitude of rapid accelerations and decelerations with sustained periods at both high and low speeds.

During this test, inspection of all bolt torques on the flanges were made periodically. An inspection of the lower half of the housing made after 50 hours of operation indicated that no erosion or deterioration of the housing had occurred. At the end of 150 hours, the housing was in excellent condition with every indication that it could continue to operate successfully for thousands of hours.

Discussion

This housing was fabricated using a composite structural cloth reinforcement and glass mat reinforcement. The strength of this particular housing was more than enough, since pains had been taken to overdesign the part.

Design considerations indicate that the housing could be fabricated from an all-glass mat reinforcement, thereby suggesting the use of glass mat preforms for aviation gas turbine housings. If such glass mat preforms were utilized, the cost of fabricating the housings could be dramatically reduced.

Although no exact cost estimates were made on this molded part, it is expected that similar plastic housings could be produced for less than ½ the cost of similar magnesium housings. Magnesium is an expensive alloy, and these alloy housings require extensive and exacting machine work to insure accurate dimensions. These dimensions are all achieved with the reinforced plastic housing in the initial machining stage and no additional machining is required. The engine tests indicate that the plastic housing performed as well as, or better than conventional metal. The engine tests were made on an exceptionally cold day and the cold ambient limited the maximum temperature of the housing at the exit end to 350°F. A distinct advantage of plastic was found when it was noticed that the clearance between the moving blade tips and the molded housing remained much smaller than metal housings. The lower thermal expansion of the plastic prevented excessive clearances in the housing with the result that better air pressures could be maintained.

The use of reinforced plastics in the structural application of compressors for jet engines suggests an entirely new, exciting area for exploitation by the plastics industry. The structural advantages and lack of corrosion of the glass reinforced plastic parts should be of interest to commercial aviation engine manufacturers as well as to the military. Rocket casing and missile components should be, and are being, investigated. Many gas turbines are being constructed at the present time for power supply on land based installations, and reinforced plastic compressors are entirely feasible for these units wherein environmental resistance is essential. This study proves the exceptional properties of glass-reinforced plastics again and suggests the use of these materials as structural components in aviation and land based gas turbine structural applications.

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1. Van Antwerp, Plast. Tech., Vol 6, No. 6, p. 44.

Acknowledgment

The assistance and cooperation of R. D. Fraser, Westinghouse Electric Corporation, in design, final test and project coordination is gratefully acknowledged.

edited by **George Lubin,**
Grumman Aircraft Engineering Corporation

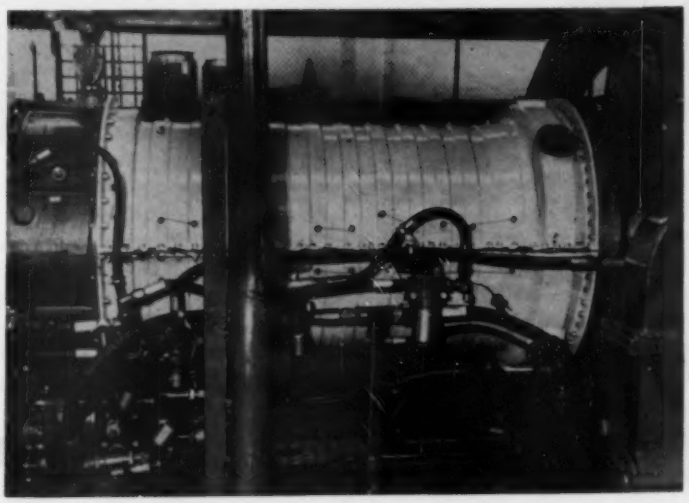
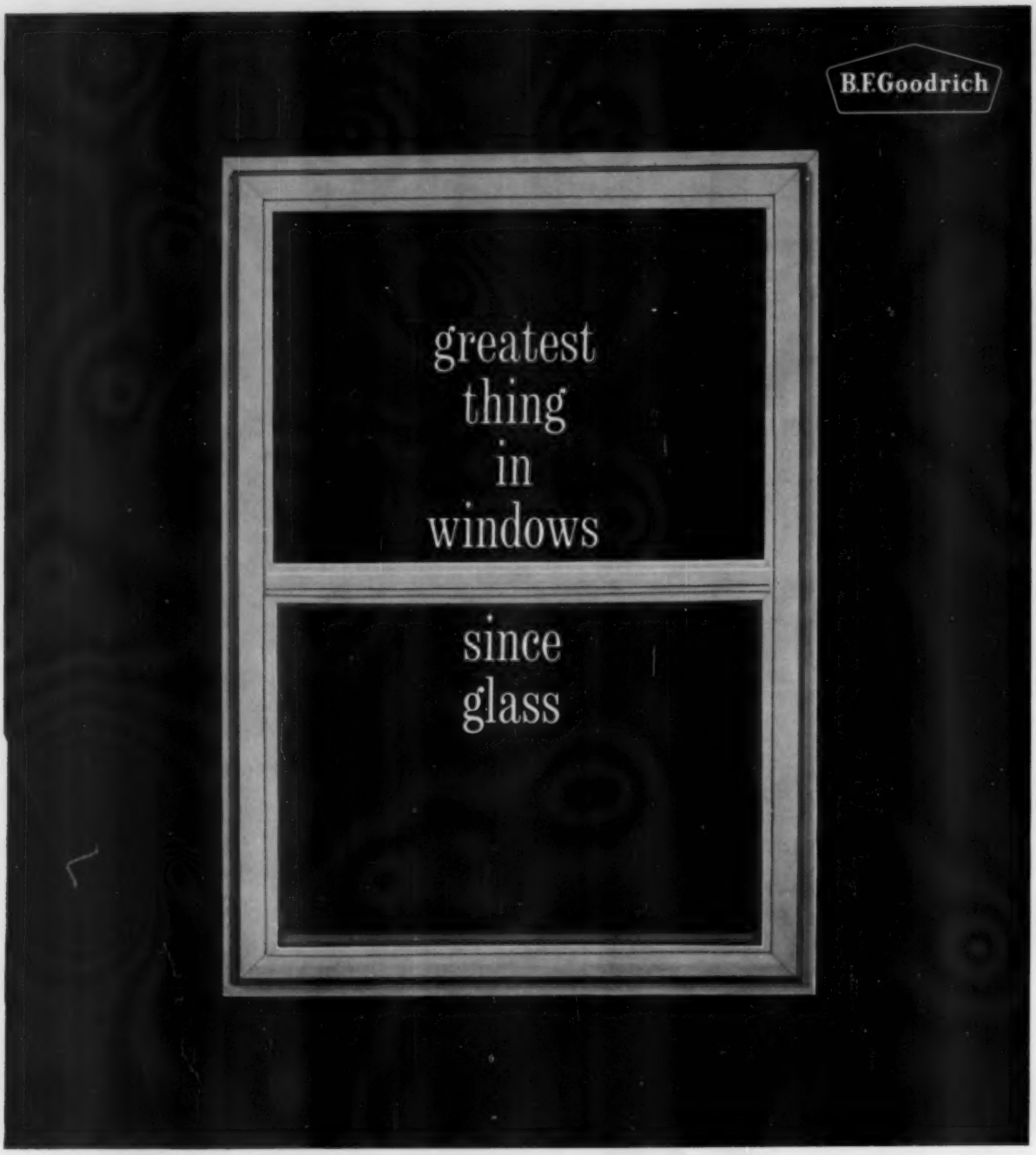


Figure 10. Jet engine with molded housing for endurance tests



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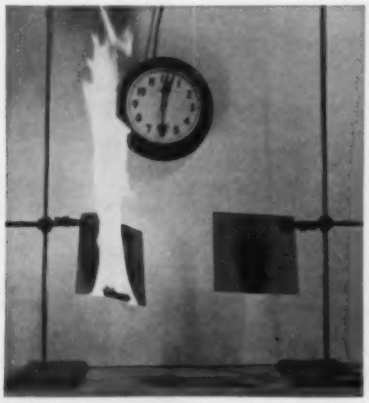

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National Bureau of Standards

STANDARDS FOR PLASTICS

Long-Term Working Stress of Thermoplastic Pipe

The major technical problem for some years in the design of thermoplastic pipes and in preparing satisfactory standards for these products has been the selection of working stresses for long term applications such as are required in water and gas distribution systems, both inside and outside of buildings. Short-term burst and creep tests have been shown repeatedly to be unreliable for this purpose. The pipe industry has made remarkable progress by using working stresses set by educated guesses, limited experience, and cautious recommendations for applications such as not recommending thermoplastic pipe for water pressure systems in buildings and for hot water). It has been evident that if working stresses could be set by a more realistic standard method that plastic pipe would be more readily accepted by architects, builders, code officials, engineers, piping system designers, and others concerned with selecting materials for use in water and gas distribution systems and that the potential growth for thermoplastic pipe would be increased tremendously. Recognizing the scientific problems involved and the value to the industry, the Thermoplastic Pipe Division of the Society of the Plastics Industry (SPI) established a Working Stress Subcommittee in November 1958 to develop a method for estimating long-term strengths and working stresses. This resulted in the adoption by this SPI Division of a "Tentative Method for Estimating Long-Term Strength and Working Stress of Thermoplastic Pipe" in January 1961. Although this was the eleventh draft, the Division and the Subcommittee cautions that the method is tentative and may be subject to further extensive revision.

The Thermoplastic Pipe Division of The Society of the Plastics Industry recently approved the obtaining of necessary background information on the Tentative Method for Estimating the Long-Term Strength and Working Pressure of Thermoplastic Pipe

During the course of the work, the available literature in the field of interest, and all the stress failure time and creep test data that could be obtained were studied and analyzed. This resulted in the preparation of seven drafts of the method, some differing markedly from others. At this stage, the best data available were selected and studied to test the soundness of the seventh draft, with help from a panel of six statisticians. The eighth draft which resulted from this phase was sent to about 70 selected individuals for comment. The comments were studied and the ninth draft prepared which was sent to about 80 selected individuals for comment (most of these were in the first group of reviewers). The comments on the ninth draft were studied and the tenth draft was prepared which was sent to letter ballot of all the members of the SPI Thermoplastic Pipe Division and to about 300 other individuals for comment (including all the previous reviewers, all those on the mailing list of the SPI Thermoplastic Pipe Division, and all the members of Subcommittee XVII on Thermoplastic Pipe of ASTM Committee D-20 on Plastics). The method passed the letter ballot of the Division, but, at the request of the Working Stress Subcommittee was not approved by the Division officers. The delay was requested to allow time to study the comments received which resulted in a revision covering only editorial and minor technical points. This revision resolved the majority of the comments and the SPI Thermoplastic Pipe Division accepted it by letter ballot. The eleventh draft (tenth

draft plus revisions) has been issued as the first approved SPI tentative method, dated January 1961. Extracts from this tentative method follow.

1. Scope

This method describes a procedure for estimating the long-term strength of thermoplastic pipe when subjected to internal hydrostatic pressure and a procedure for calculating working stresses from these long-term strength values. The method is applicable to all known types of thermoplastic pipe and for any practical temperature.

2. Definitions

(a) Working Stress (when expressed with reference to pipe and this method).—The estimated maximum tensile stress in the wall of the pipe in the circumferential orientation due to internal hydrostatic pressure that can be applied continuously for 100,000 hours (11.43 years) without failure of the pipe with a high degree of certainty.

(b) Working Pressure (when expressed with reference to pipe).—The estimated maximum pressure that the medium in the pipe can exert continuously for 100,000 hours (11.43 years) without failure of the pipe with a high degree of certainty.

(c) The following formula shall be used for the relation between stress and pressure:

$$S = \frac{P(d - e)}{2e} \text{ and } S_w = \frac{P_w(d - e)}{2e}$$

where S = stress
S_w = working stress
P = pressure
P_w = working pressure
d = outside diameter
e = minimum wall thickness

(d) Long-Term Strength (when expressed with reference to pipe and this method).—The estimated tensile stress in the wall of the pipe in the circumferential orientation that when applied continuously will cause failure of the pipe at 100,000 hours (11.43 years).

(e) Failure (for the purposes of this method only).—Bursting, cracking, splitting or weeping (seepage of liquid) of the pipe during test.

3. Significance

(a) The procedure for estimating long-term strength is essentially an extrapolation with respect to time of tests made in accordance with D 1598-58T. Stress-failure time plots are obtained for the selected temperature and the extrapolation is made in such a manner that the long-term strength is obtained for this temperature.

(b) The working stress is estimated by taking a fraction of the long-term strength, or by means of an extrapolation of the stress-failure time plot, or by estimating the stress that will give 5 percent expansion of the circumference in 100,000 hours, whichever gives the lowest value. The intent is to make allowance for the basic time-temperature-stress-strain characteristics of the material; the normal variations in the material, manufacture, and dimensions; departure from optimum handling and installation techniques; and the variations in the evaluation procedures in this method and in D 1598. The working stress obtained provides a service life for an indefinite period beyond the actual test period. Working stress values estimated by this method are not suitable for designing piping systems for special or unusual conditions or estimating the life or behavior of the pipe in contact with environments that may attack it.

(c) It is not likely that the long-term strength and working stress values for a specific plastic will be the same as as that for other plastics. There is also some doubt that results obtained at one temperature can be used to estimate values for other temperatures, particularly higher ones. Therefore, it is essential that long-term strength and working stress values be determined for each specific kind and type of plastic and each temperature. These procedures are not based on mechanisms of failure since these mechanisms are not known but are empirical approximations, with error, if any, intended to be on the conservative side.

4. Long-Term Strength

The procedure to estimate the long-term strength shall be as follows:

(a) The inside environment for the pipe test specimens shall be water. The outside environment shall be either water or air (Note 2). Other media may be used but the environment shall be given in the test report. The inside and outside environments shall be maintained within ± 2°C (3.6 F) of the test temperature. Test results for failures that occur in less than 10 hours shall be reported but shall not be used in calculations of the long-term strength and working stress.

(b) The outside diameter shall be obtained by averaging measurements made on each specimen before test. At least 4 measurements approximately equidistant around the pipe shall be made on each specimen to the nearest 0.010 inch. The minimum wall thickness shall be determined before test to the nearest 0.001 inch.

(c) A minimum of 18 failure stress-time points shall be obtained for each selected temperature. The stress values for test shall be selected as follows:

Hours	Failure Points
10– 100	At least 3
100–1,000	At least 2
1,000–5,000	At least 2
After 5,000	At least 3
After 10,000	At least 1
	Total At least 18

The internal test pressure in each specimen corresponding to the selected stress shall be maintained within ± 5 psi or within ± 1 percent of this pressure whichever is greater. Specimens that have not failed after being under test for more than 10,000 hours may be considered as failures for the purpose of calculating long-term working stress by this method at the discretion of the operator; the report shall include the stress time. The results of the tests with each specimen shall be plotted with the stress in psi as the ordinate and the logarithm, to the base 10, of the time-to-failure in hours as the abscissa (Note 2). The time-to-failure versus failure stress data shall be represented as a linear plot on semi-log paper and the line shall be drawn by the method of least squares. The plot shall be extrapolated to 100,000 hours to find the long-term strength which is the stress corresponding to this intercept.

(d) The suitability of the data for use in determining the long-term strength and working stress of plastic pipe shall be determined as follows:

(1) Extrapolate the fitted line to a log time value of 5.0, and find the extrapolated stress value;

(2) Calculate, the lower confidence value of stress at this point;

(3) If the lower confidence value differs from the extrapolated value by more than 25 percent of the latter, or M is zero or negative, or b in the equation $h = a + bf$ is positive, the data shall be considered unsuitable (h = logarithm of failure time in hours, f = failure stress in psi, and a and b are constants).

5. Circumferential Expansion

(a) The expansion of the circumference in the center of that section of the pipe specimen that is under test shall be measured to the nearest 0.001 inch periodically (Note 3) during the test. The changes in circumference shall be calculated as percent of the initial outside circumference and plotted linearly against time in hours on log-log graph paper. The line shall be drawn by the method of least squares with time as the independent variable. The expansion of the circumference in percent at 100,000 hours shall be taken from each plot by extrapolation or shall be calculated by the equation, $c = a' + 5.00\ b'$, where c = logarithm of

Note 1. Weeping type failures are difficult to detect when the outside environment is water. It is recommended that where oxidation may be involved or when weeping type failures are expected that the external environment be air.

Note 2. It should be noted that contrary to the custom in mathematics, the independent variable (stress) is plotted on the vertical (y) axis, and the dependent variable (time) on the horizontal (x) axis. The plotting procedure in Appendix III has been adjusted for this.

Note 3. It is suggested that these measurements be made once every 24 hours during the first 5 days, once every 3 days during the next 6 days, and once a week thereafter. The periods shall be selected on the basis of past experience with the type of pipe so that they will be reasonably distributed to obtain a good plot.

circumferential expansion in percent, and a′ and b′ are constants. Extrapolations of curves for specimens that fail in less than 1000 hours shall not be used.

Plot the corresponding expansion-stress points from the 100,000 hour intercept on log-log graph paper and draw a line representative of these points by the method of least squares with stress as the independent variable (Note 4).

6. Working Stress

The procedure to determine the working stress shall be as follows:

(a) Divide the long-term strength by 2.0 (Note 5).

(b) Calculate the value for f in the equation $h = a + bf$ using 5.6415 for h.

(c) Read from the circumferential expansion-stress plot obtained in Section 5 (a) and Appendix II, the stress corresponding to a circumferential expansion of 5.00 percent. This stress may be obtained by calculation, if desired. The stress is the antilog of r in the equation $c = a'' + b''$, where r = logarithm of stress in psi and a and b are constants. → c is 0.6990.

(d) The working stress shall be the lowest of the three values resulting from 6 (a), 6 (b) and 6 (c) provided the data meet the requirements in Section 4 (c).

7. Working Pressure

(a) The working pressure for each diameter and wall thickness of pipe shall be calculated from the working stress for the specific material in the pipe by means of the equations in 2(e).

Approach

The Subcommittee recognizes that the procedure described is essentially empirical in nature. The more basic approach described in the literature and suggested by others were considered with the hope that such an approach could be used. Early drafts were more basic. However, the testing against the best data available showed that only an empirical approach could be used at present. This should not be construed to mean that the basic procedures for analyzing stress-time data are in error, but rather that the pipe test data in this area are not adequate and/or are not of sufficient overall quality to select the proper basic theory. The Subcommittee hopes that the use of this method will result in the accumulation of sufficient data of the proper quality to result in a revision of the method to a more basic approach within two or three years after its adoption.

Note 4. If the stress range is less than one log decade, it is suggested that additional tests be made at lower stress loads so that the stress range will be greater than one log decade.

Note 5. It should be noted that this is not a safety factor for use in designing piping systems.

Materials

The data used to evaluate this method were obtained with thermoplastic pipe made of polyethylene, acrylonitrile-butadiene-styrene, vinyl chloride, and cellulose acetate butyrate plastics at room and elevated temperatures. The method is considered at present to be tentatively applicable to these four plastics for any practical temperature. It is suggested that the method be used to estimate long-term strengths and working stresses of pipes made of all thermoplastics until further experience is accumulated. Data obtained by this method can be readily analyzed in ways other than those prescribed by the method. The method will serve to accumulate test results in a standard manner and thus make analyses comparable and more meaningful.

Plotting Coordinates

The Working Stress Subcommittee during the period in which this tentative method was being developed oscillated between the use of log-log and semi-log coordinates for plotting stress-time to rupture data. Five in a group of six statisticians (each from a different laboratory) who studied the best data the Subcommittee was able to collect recommended using semi-log plots. The sixth statistician stated that the log-log and semi-log plots were of equal degree of validity.

It is the intent of the Working Stress Subcommittee to plot all the stress-time to rupture data received both on log-log and semi-log coordinates. When more and better data are available and studied, changes in the coordinates may be recommended, either for all thermoplastics or for selected materials.

Linear Plots

The data available indicate that the linear plot adopted is satisfactory and probably is better for extrapolation purposes than quadratic plots. When the basic mechanisms of the failures of thermoplastic pipe under stress are better understood, it may be possible to develop equations with quadratic terms that can be used with confidence in these extrapolations.

The few materials that yield nonlinear plots either give reasonable working stress values by this method or they are unsuitable for making pressure-rated pipe for use at the temperatures that yield plots with appreciable curvature.

Time Data

Failures that occur in less than ten hours are excluded in this method because it was found that these data (1) are highly erratic, (2) appear to result from failures by a different mechanism than those that occur later, and (3) tend to reduce the reliability of the extrapolations. It was also found that it is necessary to obtain some failure points at 10,000 hours or beyond to make reliable extrapolations to 100,000 hours.

Data that do not extend beyond 1,000 hours do not generally give reliable extrapolations to 10,000 hours. The Subcommittee believes that it would be unwise from what is known about the stress-time behavior of plastics at present, to extrapolate from 10,000 hours to 1,000,000 hours. It seems that extrapolations of more than one log cycle in hours are not warranted.

The option to allow those using the method to designate tests that have reached 10,000 or more hours without actual failure of the pipe as failure points for the purpose of calculating long-term working stress by this method is made so that results can be obtained without waiting for unduly long periods. Such points would give conservative working stress values. It seems unfair to require that a manufacturer who has made tests that last one year, fifty-one days, and sixteen hours to wait for months or years longer to obtain a slight increase in a working stress value. The value could always be increased later.

Several laboratories are obtaining or have obtained data up to 10,000 hours and have found testing for this period to be within reasonable experimental control.

Safety Factor

Although in most instances decisions were made to give conservative long-term strengths, and working stresses and procedures are used that should result in a service life of 100,000 hours with a high degree of certainty, no part of this method should be construed to be a safety factor for designing piping systems. The piping engineer will need to decide for each application the particular safety factor that should be applied to the system being designed.

Assignment of Working Stresses

The use of this method to assign working stresses to plastic pipe materials requires that some well defined implementation procedure be used. Such a procedure is being developed. It is the present intent of the SPI Working Stress Subcommittee to consider using these values for standardizing the dimensions of plastic

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ASTM

This method has been submitted to ASTM Committee D-20 on Plastics for further improvement and refinement and for issuance as a joint SPI-ASTM method. Joint SPI-ASTM Subcommittee XVII in Committee D-20 has initiated a round robin testing program to evaluate the method more fully. In the meantime before it is adopted by ASTM it will be used by the SPI Thermoplastic Pipe Division to assign working stress values for use in standardizing dimensions for pipe and fittings and to serve as a standard for obtaining comparative failure stress-time data on plastic pipe.

Further Work

The Working Stress Subcommittee is collecting pipe test data from all available sources at present They intend to study the data and the method, to analyze the data in any reasonable manner with assistance from competent statisticians, to assign working stress values to materials for standardizing dimensions of pipe and fittings and to develop revisions in the method. These activities are being coordinated and carried on in cooperation with the ASTM group.

The following points should be stressed: (a) This is a tentative method prepared and adopted for temporary use by the Thermoplastic Pipe Division of SPI as a means to initiate a solution to their most pressing technical problem; (b) It is *not* an ASTM tentative method; (c) A round-robin program to evaluate it more fully is underway in ASTM which will require well over a year to complete; (d) The SPI Working Stress Subcommittee has no test data that meets completely all the requirements of the tentative method; (e) It is based on the best data that have been collected and an objective appraisal by a large group of their combined experiences of the behavior of pipe under service conditions; and (f) It must be considered as a working draft to guide experimental testing programs for collecting data on a standard basis.

It is evident that this tentative method will be the subject of much debate and controversy by those interested in plastic pipe in the near future. However, if it succeeds in leading to a solution for the major problem in the thermoplastic pipe industry, namely, agreement on realistic working stress values, it will have served its purpose well.

■

Special Note

Copies of the complete "Tentative Method for Establishing Long-Term Strength and Working Stress of Thermoplastic Pipe" may be obtained from Mr. Bert S. Montell, The Society of the Plastics Industry, 250 Park Avenue, New York 17, New York. Included are appendices which outline methods for the statistical determinations involved. Copies of a letter stating the administrative policy and procedure for handling pipe test data that are being submitted to the SPI Pipe Working Stress Subcommittee may be obtained from the chairman, Frank W. Reinhart, National Bureau of Standards, Washington 25, D. C. This Subcommittee consists of the chairman and 9 members presently, Bronis de Supinski, Marbon Div., Borg-Warner, Jean Malone, B. F. Goodrich Chemical Co., Jacob Jaglom, Corroplast, Inc., Stanley Mruk, Plastics Div., Allied Chemical, William C. Gunning, Tennessee Eastman, A. Stockfleth, Polychemicals. E. I. du Pont de Nemours & Co., Inc., Ted M. Yeiser, Crescent Plastics, Eli Schwartz, Naugatuck Chemical, U.S. Rubber Co., and Leonard F. Sansone, Jr., National Tube Div., U.S. Steel Co. Former members are Howard H. Irvin, Marbon Div., Borg-Warner, B. P. Rouse, Jr., Carroll Underwood, Tennessee Eastman, Robert L. Knapp, George Kazan, Plastic Div., Allied Chemical. P. M. Elliott, (deceased) Naugatuck Chemical, U.S. Rubber Co.

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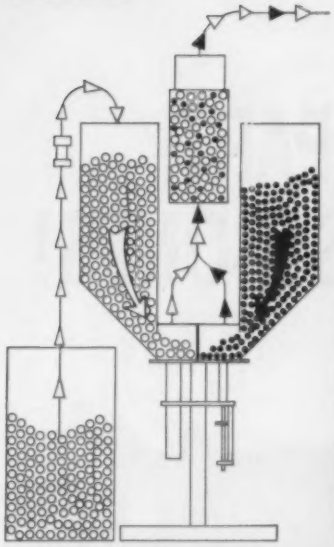

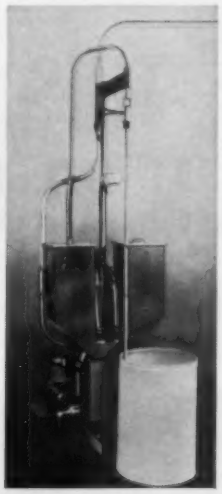

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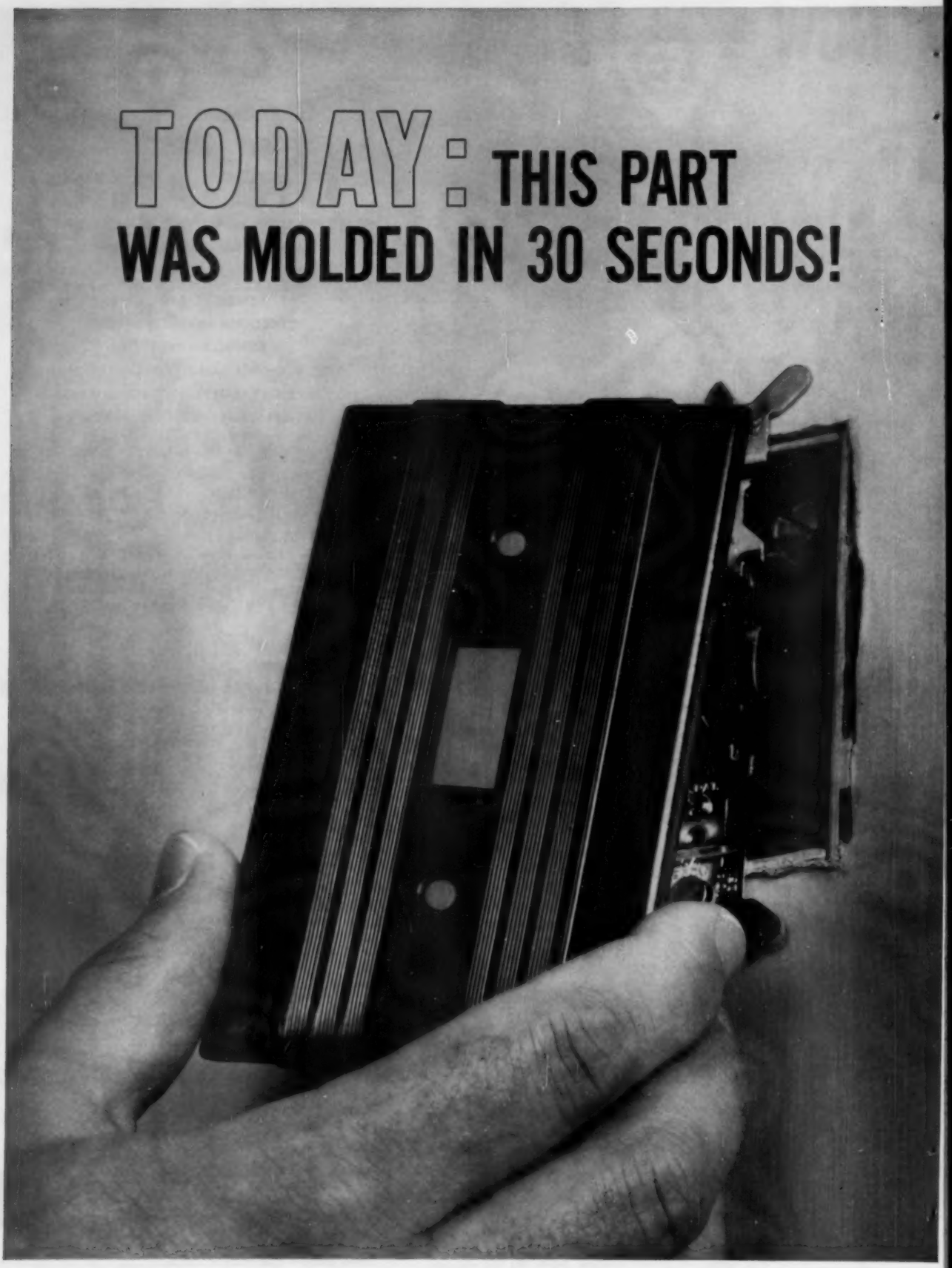
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The Effects of High Vacuum and Ultraviolet Radiation on Reinforced Plastics

Norman E. Wahl

Cornell Aeronautical Laboratory Inc.

High altitude effects on plastic materials are relatively unknown. Tests were made on glass fiber laminates reinforced with polyester epoxy and phenolic resins and results are reported here

The effects of natural environments at high altitudes, such as low pressure and solar radiation, on the properties of plastic materials are relatively unknown. This paper* concerns itself with these behaviour phenomena.

Natural environments that will be encountered in high altitude flights include the following:

1. Varied atmospheric compositions
2. Extremes of temperature
3. High vacuum
4. Solar radiation
5. Various types of cosmic radiation
6. High velocity particles

Evaluation of plastic materials by exposing them to all of these elements in the laboratory, simulating actual conditions, would be a task of considerable magnitude. In this preliminary study, therefore, the elements selected were those that can be readily simulated and which may have especially significant effect on materials. These elements are heat, ultraviolet and high vacuum. Solar radiation and upper atmosphere pressure effects will first be reviewed.

Solar Radiation

Recent rocket explorations of the upper atmosphere have given new data on the solar constant. The solar constant is defined as the rate at which energy is received upon a unit surface, perpendicular to the sun's direction, outside the earth's atmosphere at its mean distance from the sun (1.495×10^{13} cm or 92.9×10^{6} miles). The best value for the solar constant is 2.00 cal cm^{-2} min^{-1} or 0.14 watts cm^{-2}. This corresponds to a solar illuminance constant of 13.67 lumens per square centimeter. These values have a probable error of $\pm$ 2 per cent.

The solar energy spectrum outside the earth's atmosphere consists of electromagnetic radiation ranging from 1 to 100,000 Angstroms. This entire energy spectrum is important when one considers the effects on materials in outer space, but it is believed that the ultraviolet portion of the spectrum will have the most degrading effect on paints, plastics and elastomers.

The approximate energy distribution of solar radiation, the wavelength and the type of radiation are shown in *Figure 1*.

As solar radiation travels outward from the sun it is believed to be unaffected until it strikes the earth's atmos-

* The work reported herein was sponsored by Materials Central, Wright Air Development Division under Contract AF 33(616)-6267 and was extracted from WADD Technical Report 60-125, February, 1960.

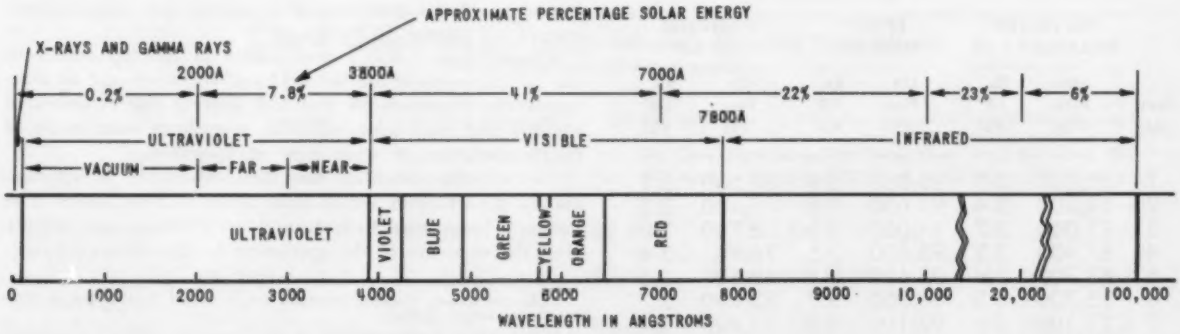

Figure 1. Spectrum of solar electromagnetic radiation and approximate distribution of energy

Table 1. Atmospheric Pressure at Increasing Altitude

Altitude Feet	Approx. Atmosphere Pressure mm of Mercury
50,000	87.4
100,000	8.3
200,000	1.7×10^{-1}
300,000	1.3×10^{-3}
1,000,000	1.3×10^{-9}

phere. After the solar energy has traveled a short distance through the earth's atmosphere, all the wavelengths below 2800 A and over fifty per cent of the ultraviolet between 2800 and 3800 A, are absorbed.

Upper Atmosphere Pressure

The pressure of the atmosphere decreases as the altitude increases. *Table 1* was compiled from the ARDC Model Atmosphere given in Geophysics Research Directorate, 1956, "Abbreviated English Tables of Model ARDC Atmosphere".

From this table it is observed that the static ambient atmospheric pressure at 300,000 feet or approximately 60 miles altitude, is fairly low. The probable effect of this low pressure or high vacuum on some plastics and elastomers used in the components or in aircraft construction would be to remove the low molecular weight fractions of these materials by evaporation. With the added effect of heat and/or ultraviolet radiation, the vapor pressure of these materials would be higher and would cause an unpredictable loss in weight and change in properties.

Test Equipment

The ultraviolet source for this work consisted of a high-pressure, quartz, mercury-vapor lamp. This Osram HBO-107 lamp, made in Germany, produces ultraviolet radiation from an arc ranging from 2500 to 6000 angstroms with peak intensities, stated by the manufacturer, at approximately 3000, 3650, 4000, 4300, 5400 and 5700 angstroms. This lamp was selected since it had the highest luminous efficiency and gives off very little infrared radiation. Since the lamp operates in a vacuum chamber, any great quantity of heat buildup would not be readily removed by conduction or convection.

Table 2. Control Specimens Not Exposed to Ultraviolet Radiation and Vacuum

Ultimate Flexural Strength and Moduli of Glass Reinforced Laminates

	POLYESTER PARAPLEX P-43		EPOXY EPON 815		PHENOLIC 91 LD	
Spec. No.	Ult. Flex. PSI	Ex. 10^6 PSI	Ult. Flex. PSI	Ex. 10^6 PSI	Ult. Flex. PSI	Ex. 10^6 PSI
1	88,600	3.9	95,000	3.9	88,500	3.7
2	62,200	3.4	93,600	3.8	69,400	3.5
3	75,000	3.7	94,000	3.5	86,700	3.8
4	67,400	3.3	92,600	3.5	76,800	3.6
5	63,200	3.4	96,600	3.6	69,800	3.5
6	75,700	3.5	98,200	3.7	85,700	3.7
7	73,100	3.6	97,100	3.8	62,400	3.4
Avg.	72,170	3.5	95,300	3.7	77,040	3.6

The Osram mercury vapor lamp is said to be designed to operate very steadily so that the radiant output is essentially constant. The light intensity, however, tends to be reduced during the life of the lamp which was found to be in the range of 100-125 hours depending on the number of starts.

The high vacuum equipment used is a Kinney PW-400 unit consisting of a KC-15 mechanical pump, a fractionating oil diffusion pump and a liquid nitrogen trap. The vacuum chamber is an 18" diameter, 30" high Pyrex bell jar mounted on a 20" diameter stainless steel plate. This system, with the use of the liquid nitrogen trap, will attain a pressure of about 1.0×10^{-6} mm of Hg pressure (3.94×10^{-8} inches Hg) in about four hours. The pressure is measured by an ionization gauge between 10^{-6} and 10^{-7} mm.

Preparation of Test Specimens

Three laminates, nominally ⅛" x 18" x 18", were prepared for these environmental tests. One laminate used 12 plies of 181-A172* glass cloth with Rohm and Haas Paraplex polyester resin; one laminate used 12 plies of 181-A1100 cloth using Shell Epon 815 epoxy resin; and one used 12 plies of 181-A1100 with CTL-91LD** phenolic.

The P-43 was catalyzed with 1% benzoyl peroxide and the polyester laminate was press-cured at 25 psi and 130°F for 1 hour, then for 1 hour at 250°F to give transparent void-free laminate. The Epon 815 was hardened with 12 parts of curing agent T (aliphatic amine adduct) per hundred parts of epoxy resin. This laminate was cured at 25 psi for 1 hour at 200°F, then 1 hour at 250°F. The CTL-91LD prepreg laminate was cured at 25 psi and 325°F for 8 hours, then postcured for 16 hours at 350°F.

The P-43 laminate averaged 0.115" in thickness and had a resin content of 33.5 percent by weight. The Epon 815 laminate averaged 0.110" in thickness and had a resin content of 30.4 percent. The phenolic laminate averaged 0.112" in thickness and had a resin content of 30.8 percent.

The three laminates were then cut into test specimens, ⅛" x 1" x 4". For control standards seven specimens from each of the laminates were evaluated for their ultimate flexural strength and moduli of elasticity. The results obtained are outlined in *Table 2*.

Exposure of Laminates to Ultraviolet and Vacuum

Specimens of polyester, epoxy and phenolic laminates ⅛" x 1" x 4" were conditioned in an oven at 210°F for one hour, then put in a dessicator and allowed to cool to room temperature and then weighed. They were then exposed to ultraviolet radiation and vacuum in groups of four.

The six specimens were placed with the 4" x 1" side facing the mercury vapor lamp. The specimens were placed on the circumference of a 2-19/32" radius circle with the midpoint of the 4" length of the specimen at the same level as the midpoint of the mercury-vapor lamp. This arrangement resulted in ultraviolet radiant flux falling on the front face of the specimen of 2 calories per square centimeters per minute (2 Pyrons).***

A small hole (.050") was drilled in the top corner in the ⅛" thickness of the ⅛" x 1" x 4" specimen and an iron-constantin thermocouple inserted. During the exposure to vacuum and ultraviolet radiation, recordings were made of the temperature of each type of specimen.

The vacuum chamber was then evacuated to approximately 2×10^{-6} mm which took three to four hours. The mercury lamp was then turned on. Within one minute after the exposure of the specimens to the ultraviolet radi-

* 181—An Owens Corning Fiberglas fabric weave. A-172 and A-1100 are Union Carbide finishes.

** CTL-91LD is manufactured by the Cincinnati Testing Laboratories, Inc.

*** Pyron: a unit of radiant intensity equal to one cal./cm^{-2} min^{-1}.

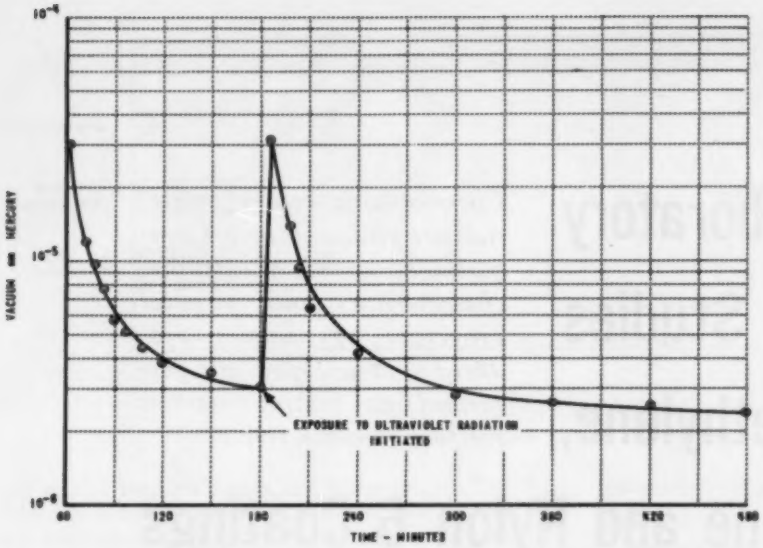

Figure 2. Typical vacuum pressure in chamber with plastic laminate specimens.

ation, the plastic laminates began outgassing and the pressure increased to the 10^{-4} mm range. A typical curve on the vacuum pressure during a test run is shown in *Figure 2*.

The position of the three types of specimens was varied on the circumference of the circle for each test period so the polyester, epoxy and phenolic were not all exposed to ultraviolet radiation from the same area on the lamp.

A series of twenty-four specimens, eight each of polyester, epoxy and phenolic were exposed to ultraviolet radiation of 2 cal cm^{-2} min^{-1} and vacuum in the 10^{-6} mm Hg range for periods of 24, 50, 200 and 500 hours.

Table 3. Percentage Loss in Weight of Glass Reinforced Laminates Exposed to Ultraviolet Radiation and Vacuum

Time of Exposure (Hrs)	Max. Temp. Reached °F	Max. Vacuum Reached mm Hg	% Loss Weight*
Polyester P-43			
24	240	4×10^{-6}	0.38
50	254	2.5×10^{-6}	0.54
200	292	1.6×10^{-6}	0.61
500	288	4.4×10^{-7}	0.78
Epoxy Epon 815			
24	268	4×10^{-6}	0.43
50	273	2.5×10^{-6}	0.51
200	294	1.6×10^{-6}	0.58
500	319	4.4×10^{-7}	0.83
Phenolic CTL-91 LD			
24	238	4×10^{-6}	0.38
50	269	2.5×10^{-6}	0.35
200	277	1.6×10^{-6}	0.64
500	342	4.4×10^{-7}	1.30

* Average eight specimens

Results of Exposure Tests

After the various periods of exposure to vacuum and ultraviolet, the specimens were put in a dessicator and then taken from there and reweighed. The loss in weight, maximum temperature and lowest vacuum pressure attained during the tests are summarized in *Table 3*.

The specimens that were exposed to these combined environments were then tested for ultimate flexural strength and flexural modulus. The data obtained are outlined in *Table 4*.

Summary of Results

Exposure of polyester, epoxy and phenolic glass reinforced laminates to ultraviolet radiation and vacuum environments for varied periods up to 500 hours resulted in weight losses, due to evaporation, of approximately one percent for the three types of laminates.

The polyester laminate had a significant increase in flexural strength up to 200 hours exposure which can be attributed to further crosslinking. After 500 hours exposure the ultimate flexural strength had decreased but it was slightly greater than the original strength.

The epoxy and phenolic laminates lost approximately 10 per cent of their original strength after five hundred hours of exposure.

These preliminary tests seem to indicate that exposure, for periods up to 500 hours, to ultraviolet in the range of 2000 to 4000 Angstroms and pressures in the 10^{-6} mm Hg range does not have significant effect on the weight loss and flexural strength.

Table 4. Comparison of Average Ultimate Flexural Strengths of Glass-Reinforced Laminates

	Control		24 Hrs. Exposure		50 Hrs. Exposure		200 Hrs. Exposure		500 Hrs. Exposure	
Laminate	Avg. Ult. Flex. PSI	Avg. Flex. Mod. x 10^6	Avg. Ult. Flex. PSI	Avg. Flex. Mod. x 10^6	Avg. Ult. Flex. PSI	Avg. Flex. Mod. x 10^6	Avg. Ult. Flex. PSI	Avg. Flex. Mod. x 10^6	Avg. Ult. Flex. PSI	Avg. Flex. Mod. x 10^6
P-43 Polyester 181 A-172	72,170	3.5	88,350	3.6	87,800	3.8	84,200	3.7	74,200	3.0
Epon 815 Epoxy 181 A-1100	95,300	3.7	91,400	3.4	88,900	3.5	91,100	3.6	86,300	3.5
91 LD Phenolic 181 A-1100	77,040	3.6	73,200	3.6	69,600	3.6	71,900	3.6	70,100	3.6

Laboratory Processing Studies of Polyethylene, Polypropylene and Nylon 6 Coatings

Thermoplastic coating materials are evaluated here. Comparisons are made of extrusion characteristics and, physical properties of samples produced and analyses are performed on coating markets for four common resins

John F. Morris, *Spencer Chemical Company*

There are available on the market today numerous resins which can easily be coated on many substrata materials to provide a heat sealable surface, a barrier for such things as moisture, greases or gases, and good flexibility at low temperatures. In addition they may anchor loose fibers or enhance the appearance of the substratum material.

Because the purpose for coating materials varies so widely we have chosen coating resins which have a wide diversity of properties in an effort to include a material which will perform satisfactorily in about any end-use application. Our choice of polyethylene, polypropylene, and nylon 6 also covers the price range which involves both the coating yield and resin costs of some of the resins available for coatings. See *Figures 1 and 2.*

When various items such as cloth, paper, paperboard and glass scrim are coated we depend on a mechanical bond for adhesion. This is accomplished by forcing the coating resin into the substratum and then bonding either by penetration or interlocking. When this bond is made efficiently, the coating cannot be separated from the base material without damaging the base material.

When such substrata materials as foil, cellophane and glassine are coated by the extrusion process we depend on a molecular attraction rather than a mechanical interlocking for adhesion. In this system the base material can usually be separated from the coating without damaging the substratum.

Because thermoplastic coating materials are essentially non-polar they do not normally exert the necessary electrochemical forces to effect a good moleclular bond. Controlled extrusion conditions such as very high stock temperatures cause rapid oxidation and will usually give these materials the polarity required to adhere to smooth surfaces. A variety of substrata primers are also employed to enhance the adhesion to these materials.

The work done in the preparation of this paper was limited to the investigation of the physical properties of polyethylene, polypropylene and nylon when coated on 40 pound per ream unbleached kraft paper, chosen because it represents the largest volume substratum by far. This limitation was made because the combinations of coating resins and substrata materials are so numerous they could not all be covered in several volumes.

Since so many physical properties of polyethylene are sensitive to only slight variations in density we have included a polyethylene resin having a density of 0.913 grams/cc.

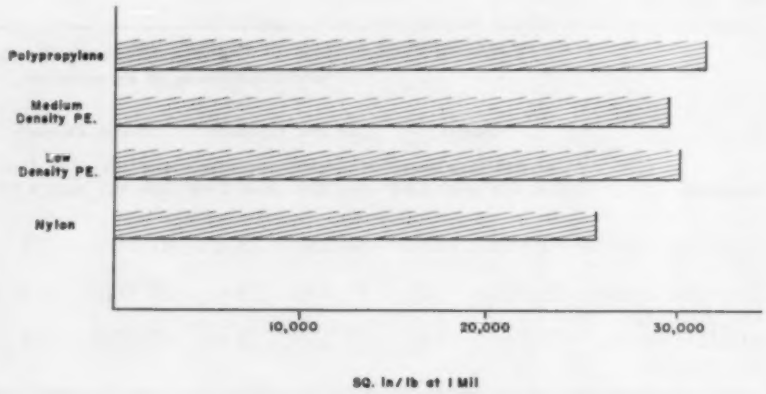

Figure 1. Coating yield per pound of resin

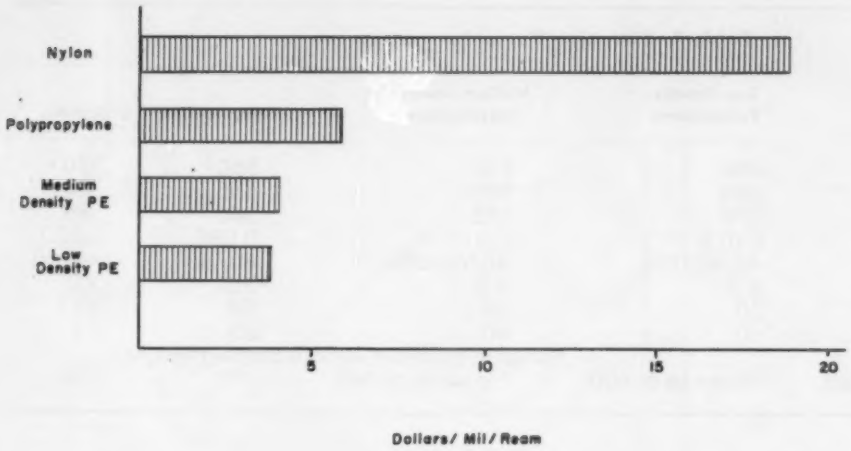

Figure 2. Dollar cost of resin coat for a 1 mil. ream

and another having a density of 0.934 grams/cc. This difference has been shown to be of significance in some end-use applications such as government barrier stocks where the quality improvement more than justifies the small cost difference.

Extrusion Conditions

In order for a thermoplastic material to be useful and readily accepted by extrusion coaters it must be easy to extrude, easy to adhere and it must give the desired end-product properties. These things must be attainable at a cost commensurate with the end-use application. The resin and substrata and therefore their costs will be dictated by the end-use application so the only variable which can be controlled by the extrusion coater is the extrusion rate. These rates are dependent on the resin used, the equipment available and the proficiency of the operators.

Many extrusion variables were attempted in the collection of data presented here and many conditions attempted were not workable. For the sake of clarity and brevity we will only present the most economical conditions for each resin which gave a satisfactory end product.

A three and one-half inch 24:1 L/D extruder was used in this work. The extruder is equipped with a polyethylene type metering screw which has a compression ratio of 4:1. This screw is not the best design for the economical extrusion of polypropylene and nylon will be observed in the coating rates attained with these products. However, this screw permitted us to obtain good quality samples which could be tested for the various physical properties which were of primary interest. Screw designs for polypropylene and nylon coatings are being investigated now and this information will be published as soon as it is available.

The extruder is also equipped with a coat hanger design die having a land length of 15/16 inch. Some preliminary work was done with a straight manifold die having a land length of 1/8 inch but it was found to be entirely unsatisfactory for nylon and polypropylene coating because of the flow properties of these materials.

Melt temperatures were measured by inserting a melt thermocouple in the adaptor between the extruder and die so the thermocouple tip extended one-half inch into the melt stream.

The screw speeds were adjusted to produce outputs that would give a range of coating weights within the capabilities of the extrusion coater.

The extrusion coater is an laboratory model having a chill roll diameter of 14 inches, and a speed range from 20 to 600 feet per minute.

The extrusion variables used for the samples were tested for physical properties and are listed in *Table 1*.

Sample Properties

The coated samples were then tested and the results are outlined below. Properties were measured on a weight basis as pounds of coating per ream.

Adhesion

The adhesion testing was done first to make sure that the best possible samples had been selected from the multitude of samples produced during the extrusion process.

This testing was done with a Southwick-Perkins bond strength tester. The results which are produced by this instrument are reported as a ratio of the burst pressure of the coating with the coated side toward the low pressure side over the burst pressure of the coating with the coating to the high pressure side. When this ratio is multiplied by 100 we have a percentage value. The values shown in *Figure 3* confirmed that we had selected the best samples for further testing. The end-use application, of course, will determine how much adhesion is necessary for a given coating weight of a particular material.

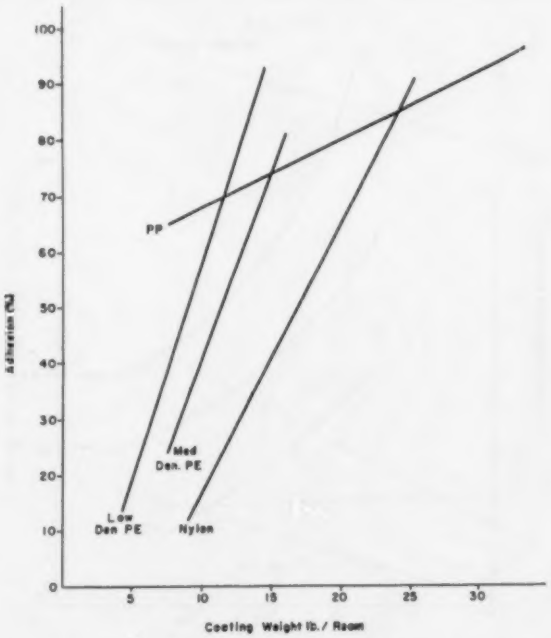

Figure 3. Adhesion versus coating weight. Note the high minimum coating weights of nylon and polypropylene and the low adhesion at lower coating weights for nylon

Table 1. Extrusion Variables

	Low Density Polyethylene	Medium Density Polyethylene	Polypropylene	Nylon
Extruder Temperature, °F.	600	600	550	570
Die Temperature, °F.	600	600	555	580
Melt Temperature, °F.	570	585	560	580
Die Opening, inches	0.015	0.015	0.020	0.020
Screen Pack	40/60/80	40/60/80	60/80	40/60
Air Gap, inches	2.5	2.5	3.0	3.0
Screw Speed, rpm.	50	60	50	22
Chill Roll Temperature, °F.	60	60	65	70
Web Speed	— Variable to obtain various coating weights —			
Web Speed at Surge, feet/minute	No surge at 600	No surge at 600	190	220

The two outstanding items about this graph are the high minimum coating weights for nylon and polypropylene and the relatively low adhesion value for the lower coating weights in nylon. These high minimum coating weights are attributed partially to screw design used in this work. A poor adhesion at the lower coating weights for nylon may be attributed to the narrow melt range for nylon. By the time these thin coatings get to the paper they are partly solidified on the surface and so the difficulty in making a good mechanical bond is exaggerated. These factors will be overcome as more people get more experience in using these resins for coating.

Moisture Vapor Transmission Rates

The moisture vapor transmission rates were determined according to methods set forth in various military specifications. This method involves sealing a sample of the coating across the mouth of a cup containing a dessicant. This cup is placed in a cabinet which is maintained at 90 percent relative humidity and 100°F. The dessicant which absorbs moisture through the coating is weighed periodically to determine a transmission rate through the coating.

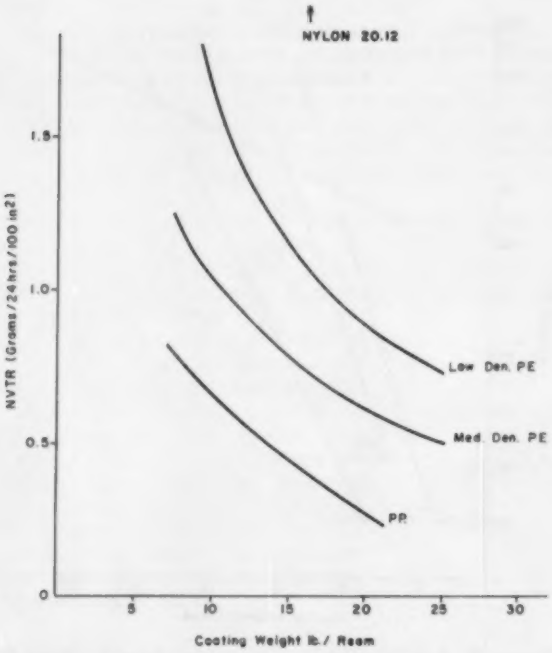

Figure 4. Moisture vapor transmission rate versus coating weight. Nylon displays very poor qualities here

Figure 4 shows the difference in moisture vapor transmission rate (MVTR) caused by a two percent difference in density in polyethylene. It also shows that the MVTR for polypropylene is considerably better than either polyethylene tested on a weight basis.

Although nylon certainly has some moisture barrier properties, it cannot be considered an effective moisture barrier within the limits of our terms of reference in the extrusion coating business.

Greaseproofness

The greaseproofness test which was done in this work was designed to give a quantitative value rather than a pass or fail value as is the case in the methods described by the government specifications.

The method specifies that the samples shall be creased diagonally and a kerosene and dye mixture shall be placed on the coated side of the intersection of the crease. When the red dye shows on a white filter paper under the kraft paper the sample is considered to be at the failure point.

Figure 5 shows the relationship between the various materials in our test work. This test leaves something to be desired because it showed no failures with nylon coatings at any thickness in 1000 hours. This precludes any quantitative judgment as to the greaseproofness qualities of nylon coatings except that they are excellent in this regard. The turpentine dye carrier caused the polypropylene samples to fail immediately so again no comparison could be made.

An attempt to make the test more severe to show nylon failures resulted in the polyolefin samples failing immediately so no basis of comparison could be achieved. This test was designed for polyethylene but will have to be redesigned for other resins before more reliable data can be reported.

Tear Strength

The tear strength test is designed to determine the force required to tear paper or, as in this case, paper which has been extrusion coated with a thermoplastic. This procedure was based on those outlined in various military specifications.

Because of some characteristics which are peculiar to the thermoplastic resins it was necessary to modify the paper industry's Elmendorf tear test slightly. The orientation which occurs in the extrusion process causes the tear strength to be somewhat different in one direction than the other.

Using the web travel as a point of reference we see in *Figure 6* that when a tear is made parallel to the web travel, the tear strength measured in grams/mil are relatively low

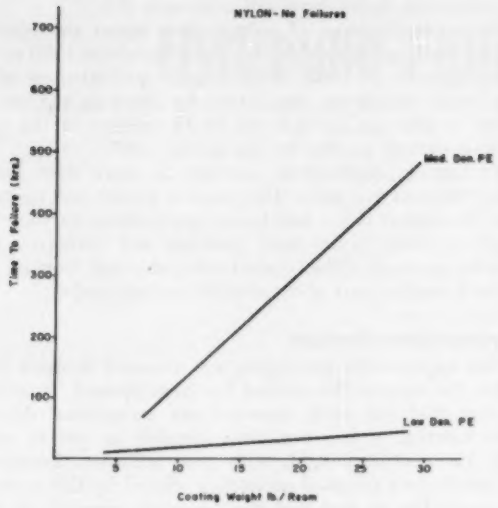

Figure 5. Greaseproofness versus coating weight. Tests measured in time to failure show that nylon has superior qualities

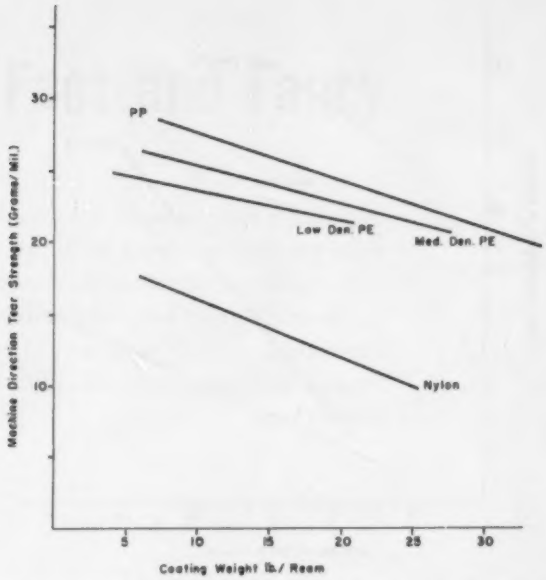

Figure 6. Machine direction tear strength versus coating weight. Nylon's properties are most inferior here

(in the range of 10 to 30). We must also notice that the results for nylon coating is the lowest in this regard.

Now in *Figure 7* we see that the tear strength was measured in the transverse direction and that the values are somewhat higher (20 to 55 grams/mil). In this case the nylon coatings gave the highest tear strength

This large difference in the tear strength between the machine and transverse directions indicates that there may be some cold orientation occurring because the melt may be partially solidified before it is applied to the paper. This improvement in strengths by cold orientation is, of course, the foundation on which the nylon monofilament business is built.

Slip

The slip testing done in this work was done according to a procedure commonly used to test the slip properties of plastic films and coatings. This test involves placing a sample of the coating on a 325 gram sled and pulling it across another sample of the coating. The samples are placed face to face and the force required to move the sled is calculated to a coefficient of friction.

Slip becomes an important consideration when coatings are used in high speed machinery such as a bag former for the production of multi-wall bags. As we see in *Figure 8* polypropylene is the best resin tested with low density polyethylene coming in a poor fourth. In cases where this is a critical factor it can be improved to almost any degree with the use of additives.

Gloss

The gloss values are determined with a Gardner gloss tester using a 60 degree head. This is a measure of the amount of light reflected from a given surface and has primarily to do with the asthetic appeal of a finish coated product. As we see in *Figure 9* the polyolefins improve in gloss as the coating weight increases in the range we studied. Nylon, however, loses its gloss as the coating weight gets heavier, again adding weight to our theory that some cooling is occurring in the lower coating weights before the resin is applied to the paper.

Polyethylene Coating Markets

Polyethylene became the largest volume plastic in sales history in 1958. If all the announced plans for plant expansions are completed on schedule the capacity will have increased to over 1,550,000,000 pounds with more than 1,220,000,000 pounds being of the medium and low density types.

Probably one of the largest market growths we will see in the near future is the use of polyethylene coated milk

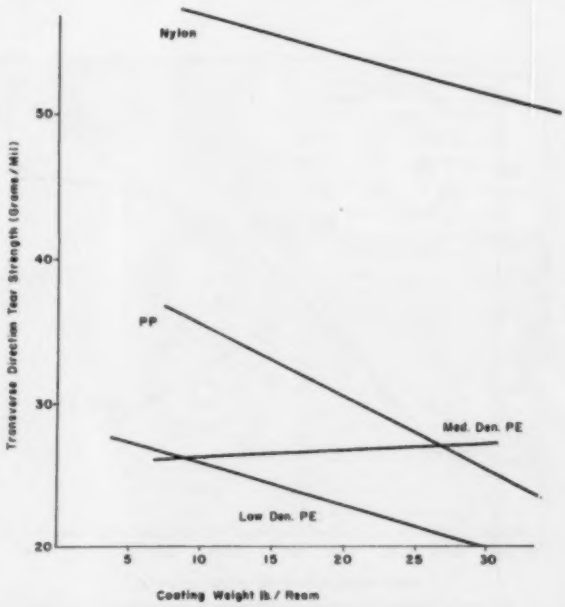

Figure 7. Traverse tear strength versus coating weight. Nylon exhibits excellent properties most likely due to cold orientation

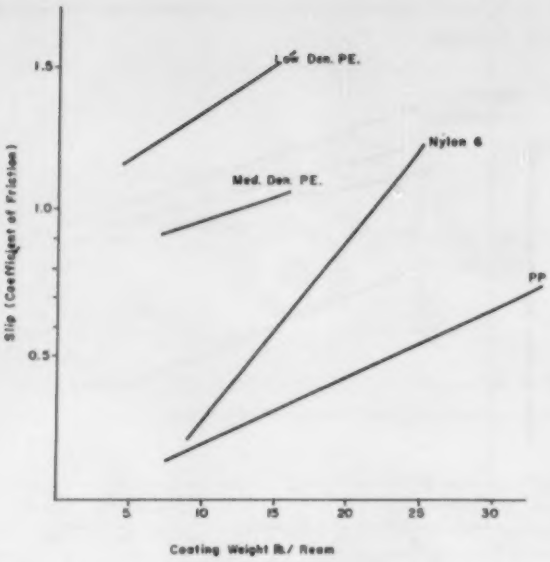

Figure 8. Slip versus coating weight. Polypropylene shows the least slip

cartons. Over 50 per cent of the milk consumed in the United States today is packaged in paperboard containers. The per capita consumption of milk is relatively stable at just over 160 quarts annually. Approximately 500,000 tons of milk carton stock are needed each year for the 10 billion or more paperboard containers produced. The majority of this stock is now coated with wax which is generally fortified with a small amount of low molecular weight polyethylene.

Several companies are now offering a polyethylene coated milk and dairy product carton on a commercial basis. These

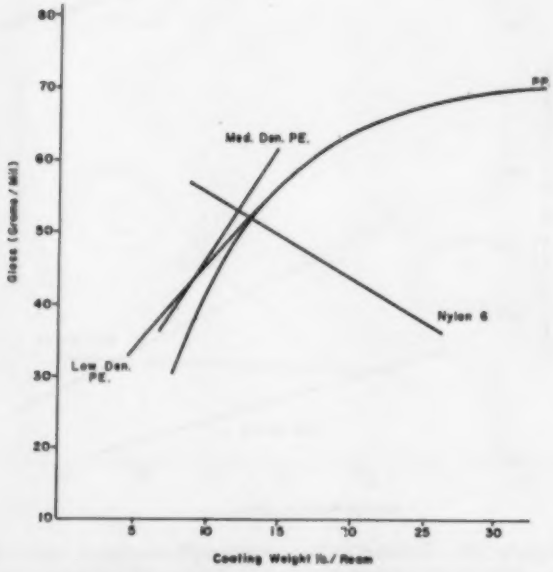

Figure 9. Gloss versus coating weight

cartons carry a premium price but higher volumes and better production technology will overcome this.

Coating applications of polyethylene resins are expected to grow from an estimated 80 million pounds in 1960 to 140 million pounds in 1963. High density polyethylene resins have found almost no application for coatings and are expected to account for only 10 to 15 percent of the polyethylene coating market by the end of 1963.

We expect polyethylene coatings to more than double during the next five years. The greatest growth will probably be in the coated paper and board applications for such uses as milk cartons, frozen food packages and perhaps a new cigarette package. Other coated substrates will increase, but will be a smaller part of the overall coating market.

Polypropylene Markets

FDA approval for packaging was obtained in April 1960, so that the door to this market has been opened. In spite of the fact that this resin demonstrates exceptional drawing characteristics, it has not been possible as yet to attain really low coating weights with good adhesion. Because of the outstanding physical properties offered by this material, we would like to feel that the necessary research in resin manufacturing techniques and extrusion coating techniques will come very quickly.

Nylon Markets

Although nylon resins have been available to the plastics industry for a number of years, it has only been since the introduction of nylon 6 resins that it has been possible to consider the potential markets existing for nylon coatings. The difference in molecular structure provides improved extrusion characteristics which make it possible to handle in relatively normal extrusion techniques. Other type nylons presented almost insurmountable handling problems in the commercial extrusion process.

Although the complete standing of nylon coatings with the FDA is yet to be determined there are a number of food packing applications where nylon coatings could be useful. These would, of course, center around foods that contain large amounts of fats and greases.

The packaging of lubricating oils and greases for the petroleum industry represent some interesting possibilities for nylon coated board. Each quart metal can used by the oil industry costs five to six cents. It is logical to assume that packaging with either nylon film pouches or coated nylon board can represent sizable savings to the petroleum industry.

Nylon coated paper as a liner for fiber drums and corrugated boxes should be considered for packaging of industrial greases and lubricants in bulk.

The use of nylon coatings on cloth to form conveyor belts where steam sterilization is necessary represents a good potential market involving 30,000 to 50,000 pounds of resin annually.

Summary

We have seen that it is possible to extrusion coat polyethylene, polypropylene and nylon and that there are many markets available to the industry for these coatings.

A study of the particular outstanding physical properties and costs of each material will dictate our choice of materials for each end-use application.

Acknowledgment

The author gratefully acknowledges the assistance of the Technical Information and Evaluation Supervisor, Donald C. Crawford and the Market Research Department for their help in developing the data presented in this paper.

Hydraulic Fluids, Fact and Fancy

Get to know the fluid in your hydraulic system. Wise purchasing along with knowledgeable maintenance policies will result in smoother and more economical operations. This article reviews properties of fluids and appraises their causes and effects

George R. Arbocus
E. F. Houghton & Co.

Fluids used in the earlier days of hydraulic transfer of power were taken for granted. It was believed that an oil of average fluidity needed no reinforcement and that petroleum oils covered all needs. However, with the increase of speed and hazards, greater care is now being given to hydraulic oil selection. The six basic qualities now expected in a high quality hydraulic oil are listed below.

1. Rust Protection
2. Excellent Oxidation Stability
3. Demulsibility
4. Non-Foaming
5. Good Lubricity
6. High Viscosity Index

When purchasing and maintaining hydraulic oil it is necessary to be able to evaluate the following properties; viscosity, pour point, viscosity index, neutralization number, and oxidation inhibition. Color, gravity, flash and fire are properties which play a much smaller part in determining quality. The effect of these properties on hydraulic fluids is discussed here.

Oil Properties

Viscosity Index in premium industrial hydraulic oil varies in viscosity index from approximately 85 to 100. The typical S.A.E. 10 200 SUS/100°F. (90 V.I.) oil used in many plastic hydraulic applications would have the following viscosities over a range of temperature. Refer to *Figure 1*.

1050 SUS at 50°F.
500 SUS at 70°F.
200 SUS at 100°F.
100 SUS at 130°F.
76 SUS at 150°F.
46 SUS at 210°F.

In general, this grade of oil would be very suitable for the operating range of 70 to 130°F. The J.I.C. (Joint Industry Conference on Hydraulic Standards) specifies 130°F. as a maximum fluid temperature on the inlet side of the pump. Sump temperatures above 160°F. to 180°F. are classed in a "Critical Operating Zone" where volumetric pump efficiency suffers, oil viscosity becomes dangerously low, and oil deterioration proceeds at a relatively rapid rate.

Oils with viscosity indices much below 80 fall by the wayside in satisfying the day by day demand placed on hydraulic oils. They are most often used where high leakage is encountered.

Pour Point—The viscosity of an oil may be 100,000 SUS approximately 5°F above the pour point. This is approxi-

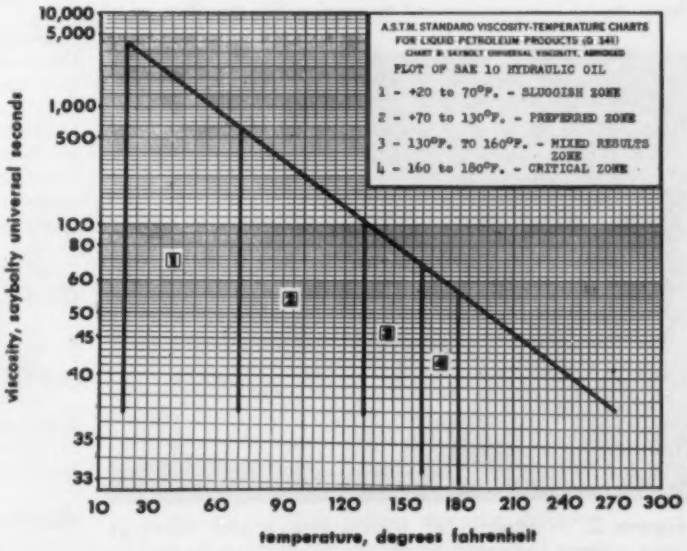

Figure 1. A viscosity-temperature plot of an SAE 10 hydraulic oil, where viscosity in SUS is given over a temperature range from 20° to 270°F

Table 1. Flash and Fire Points

SAE Rating	Viscosity @ 100°F.	Flash Point (°F.)	Fire Point (°F.)
10	190/210 SUS	390°F.	445°F.
20	290/310 SUS	415°F.	470°F.
30	500/550 SUS	430°F.	485°F.

Table 2. Oil Breakdown Reasons

Oil oxidation	54%
Water and coolant contamination	32%
Dirt	14%

mately equivalent to warm tar. At temperatures of 10 and 20°F. above the pour, the viscosity may be as high as 5,000 and 3,000 SUS, respectively. With these viscosities in mind, it is relatively easy to see that sufficient suction would be difficult and pump starvation and fluid cavitation can occur as we approach the pour point.

Rust Inhibition in hydraulic systems is at times a serious problem. In general, we find the following to be the principal causes of rust in oil hydraulic systems:

1 Broken heat exchanger lines.
2. Contamination from an outside source and these include water soluble coolants, roof leaks, and condensation.
3. Depletion of rust inhibitor.

The solutions to the problems described in 1 and 2 are self evident.

The depletion of rust inhibitor usually takes place over a period of several years. Most people change their oil before depletion ever begins. In some cases where a very large quantity of oil is involved such as one would find in a central hydraulic system feeding a large number of presses, it has been found very economical to employ 5% to 10% of a rust inhibitor. This is a satisfactory approach provided the oil is still stable as regards oxidation.

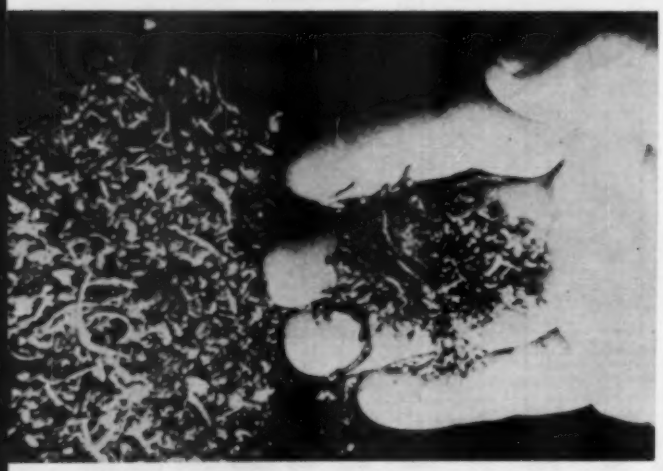

Figure 2. A sample of filings and metal cuttings which were removed from the filter of a hydraulic system. Although the filter extracted the major portion of the chips, considerable damage was done to the piston and other portions of the system before this condition was learned

Hydraulic oils are not formulated with sufficient anti-rust protection to withstand much over ½ to 1% of free water which has no place in an oil hydraulic system outside of the trace amounts that enter accidentally.

The A.S.T.M. Rust Prevention test is a useful tool in evaluating rust inhibited hydraulic oils except in cases of high water contamination, rust inhibitor depletion, and high moisture versus thin oil film, where the test becomes almost useless for rust prediction.

Demulsibility is a term which confuses many users of hydraulic oil. Hydraulic oil should not mix with water under any conditions. Accidental emulsions of oil and water are inferior lubricants for pumps and other mating parts. Good maintenance scheduling as regards drainage will overcome the possibility of some of the by products of oil degradation emulsifying the water.

Foaming—can be a troublemaker in hydraulics. High quality rust and oxidation inhibited oils seldom give a foam problem. The reason normally is not associated with the oil as received from a supplier. In our experience the following reasons are frequent causes of foam:

1. Pump intake located too close to discharge. This is overcome by baffling in the reservoir or rearranging piping.
2. Air leaks which normally produce chattering and erratic operation may also produce foam.
3. Contamination from an outside source such as a cleaning process or a machine tool coolant.
4. "Dirty oil" which has built up a combination of by-products which induce foam.

Anti-foam agents are employed quite frequently as a rapid method of controlling foam.

Lubricity is measured in the laboratory with a wide variety of machines. Such equipment as the Shell 4 Ball machine, the Cornell Machine, and the Almen machine have all been used. Pump wear could be a cause of poor lubricity in your oil.

Neutralization Number is a measure of acidity. When the values exceed 2.0 it is time to change oil or investigate the system further.

Flash and Fire Points for fire-resistant hydraulic fluids are becoming important in molding. As molding temperatures increase beyond the flash points of oil, the need grows more pronounced. *Table 1* lists typical premium grade hydraulic oils with their respective flash and fire points.

Oil Breakdown

The result of a study over a two year period of over 1400 hydraulic systems indicates that the factors listed in *Table 2*, are prime reasons for oil breakdown.

Two examples of contaminated oil are shown in *Figures 2 and 3*, respectively, depicting metal cuttings and deposits of resinous material, oxidized oil and asbestos taken from hydraulic systems.

Accelerated Testing

During the past ten years much emphasis has been placed on accelerated bench tests to determine oil quality.

Attempts have been made to define a test program which would take into account time, temperature and catalysts used in simulating the system and thus determine the su-

Table 3. Fire Resistant Hydraulic Fluid Appraisal

Type of Fluid	Fire Resist.	Cost (X Oil)	Vis. @ 100°F. Vis. Index	Packing Recom.	Comments
Water-Glycol	Best	3-4	80-1000 SUS 140 V.I.	All O.K. Except Cork and Impreg. Leather	Do not use over 130-140°F. Check with supplier for paint, filter, install. and maint. recom.
Phosp. Ester	Second	5-7	80-1000 SUS −30 to +30 V.I.	Butyl Silicon Teflon Nylon All O.K.	Check supplier for paint, filter, packings recom.
Emuls. (Water-In-Oil)	Third	2-3	450 SUS (Approx.) 140 V.I.	Same as oil.	Do not use over 130-140°F. Check suppliers on filters, paint, fluid control, and operating recom.

periority of any one oil. To date, unfortunately, the correlation of accelerated test values with the actual have not been too good, although very close approximations are obtained. Most oils are better tested in actual industrial use.

Hydraulic Fluid Types Available

Basically, three types of fluids aside from oil are available for hydraulic purposes, water-glycol, phosphate ester, and water-in-oil emulsion. These are important materials as fire resistant fluids for injection molding machines if a fire hazard exists.

Water-Glycol is the most versatile type, used most satisfactorily in approximately 80-90% of all applications. These fluids do not attack conventional packing media and are generally limited to applications where reservoir temperatures do not exceed 130°F. Above this temperature, water make-up can be a disturbing problem which most people overcome by using heat exchangers.

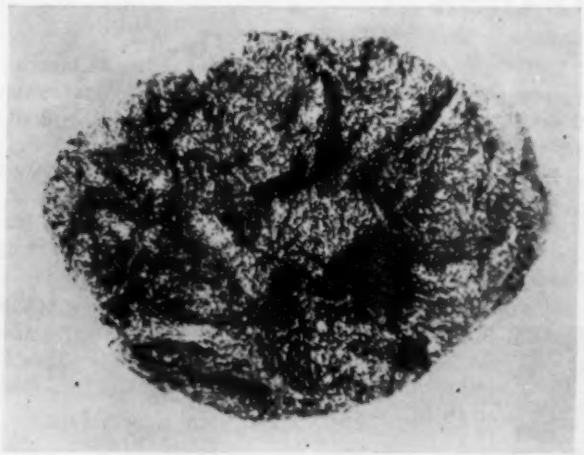

Figure 3. Filter deposit of resinous material, oxidized oil, and asbestos taken from the hydraulic system of an injection molding machine not properly cleaned out

Phosphate Ester fluids are used in hydraulic applications which operate over 140-150°F., in installations where pumps have heavily loaded anti friction bearings, and in high pressure systems.

Emulsion Fluids are attracting wide attention in the fire-resistant field. These are "water-in-oil" combinations of oil, water and emulsifier.

These fluids are finding their way into applications with moderate or remote fire hazards and in systems with light or medium duty cycles. Each potential application must be viewed from the basis of hazard, equipment design and production demands. *Table* 3 appraises the three types of hydraulic fluids.

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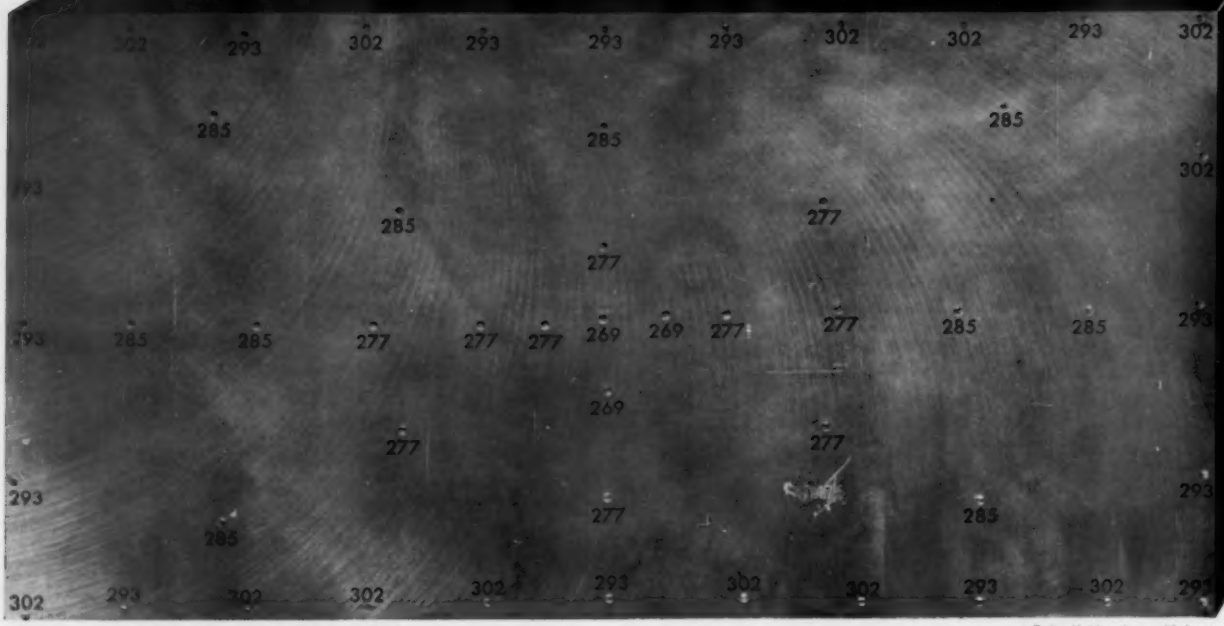
6. Applied Hydraulics Magazine, *Fluid Power Directory*. This is a compilation of basic and advanced theory and a directory of hydraulic component suppliers.
7. U.S. Steel National Tube Division, *Lubrication Engineers Manual*. A loose-leaf bound treatment of lubricant tests which is periodically revised.



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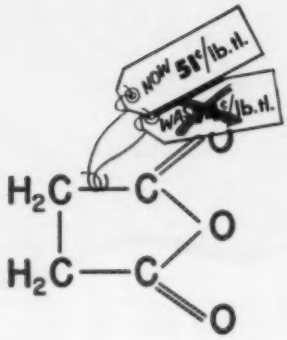

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Travis H. Meister
Chairman, Plastics in the Automotive Industry PAG
(Ford Motor Co.)

PAG Develops Comprehensive Program to Serve Automotive Industry

The Plastics in the Automotive Industry PAG recently completed its first year of existence which was one of basic organization and growth. Arrangements were made for the publication of six articles on plastics in the SAE Journal. These well received articles are being published as a brochure by the Society of Automotive Engineers and will be distributed to one thousand members. This initial effort is in the realm of the Group's main objective, which is "to disseminate technical information on plastics to the automotive engineer."

The automotive industry presents a tremendous potential for the plastics industry and it is imperative that its engineers have guidance and accurate, up to date information in an ever-changing field. As with most industries, the automotive industry is conversant in metals, but definitely not in the plastics field. To accomplish this objective, five permanent committees have been established within the PAG.

1. *Automotive Mailing List*—This committee prepares a list of automotive design engineers, who may or may not be SAE members. It also includes designers in the major automotive supplier industry. To date, 1,000 names have been selected by the committee to receive information.
2. *Literature Screening*—A survey of literature in the SPE Journal and other trade publications will be undertaken. Those articles or papers pertinent to the automotive industry will be available to its engineers in the form of reprints or abstracts. If the Society sponsors an abstracting service, this committee's work will be simplified considerably. The extent of this project will be governed by financial ability to support it.
3. *Coordination with the Society of Automotive Engineers*—The Engineering Materials Activities Committee of SAE and its subcommittee on plastics are working together with this group in securing speakers and technical seminars for SAE meetings.
4. *Materials Definition*—This committee is compiling a plastics materials chart that categorizes these materials by their limitations, such as temperature resistance, weatherability and dimensional stability.
5. *Materials Application*—Basic requirements for specific automotive applications are being ascertained by this committee. This listing will also be helpful to raw material suppliers.

Plastics in the Automotive Industry PAG has been active in assisting the Detroit Section in its various technical programs. Several of its members were lecturers in the extremely successful plastics course offered by the Detroit Section this past winter, in conjunction with the Highland Park (Michigan) adult education program. For the past seven years, an Automotive RETEC has been sponsored by the Detroit Section and the May 9, 1961 meeting had active support and assistance from the PAG. Attendance was not only large, but the fine representation of automotive engineers attested to the interest in plastics by the automotive industry.

Future plans include not only the design engineer but also the process and quality control engineer of the captive molding shops within the automotive industry. In this area, the help of injection molding, thermosetting molding and other PAGs associated with processing will be invited.

Officers of the Plastics in the Automotive Industry PAG for 1960 were:

Chairman	— Richard C. Oglesby (Rohm & Haas Co.)
Vice-Chairman	— James Greig (Woodall Industries)
Secretary	— Carl H. Whitlock (Whitlock Associates)

The following Officers were elected for 1961:

Chairman	— Travis H. Meister (Ford Motor Co.)
Vice-Chairman	— William P. Gobeille (American Motors)
Secretary	— Harry J. McGowan (Union Carbide Plastics Co.)

Edited by **Saul Gobstein,** *Chairman PAG Executive Committee (Ferro Chemical)*

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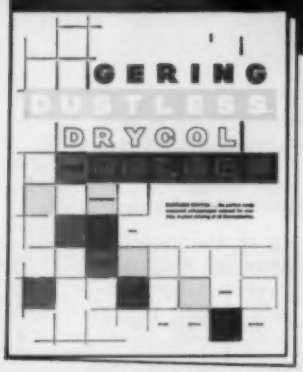

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STANDARDS FOR REPORTING PROPERTIES PAG RECLARIFIES OBJECTIVES

L. L. Lander

Vice Chairman, PAG on Standards for Reporting Properties (Union Carbide Plastics Co.)

Apparently there is yet some misunderstanding as to the purpose of the PAG on Standards for Reporting Properties. This was evidenced by comments voiced at the PAG's Annual Meeting in January and by comments received on the recent properties questionnaire.

The Executive Committee of this PAG would like to reemphasize that the purpose of this Group is to develop a standard form for the reporting of raw material properties. It is hoped that this standard form will alleviate some of the confusion which exists because all suppliers do not report data in the same manner.

To reiterate statements of past Chairman L. B. Allen in the July 1960 issue of the SPE Journal, when a design engineer is faced with comparing impact properties of various materials and some vendors use Izod and others use Charpy, the engineer is in a dilemma. It is the desire that at least Izod values be reported. If a vendor also wants to include Charpy or tensile impact values, fine; but at least report an Izod value.

Also, ASTM methods often allow a choice of specimen size. Again taking Izod as an example, it is acceptable to use 4-⅛", 2-¼", or 1-½" bars. For some materials, the Izod value varies considerably, depending upon the choice of bars. Here again, it is hoped that data be reported on the same thickness.

Another point of confusion is that data which is reported is not always expressed in the same terms. For instance, some vendors report an average value, some a minimum, and still others an arbitrary value in between the two.

It is the hope of Executive Committee of this PAG that a standardized form will eliminate some of these ambiguities. However, this form is to be a preferred form, not a mandatory one. In addition, it is not expected that all properties will be reported on all materials, nor is it intended that this list be all inclusive. Reporting of properties other than those on the list is encouraged. In fact, the list is meant to be flexible, so that revisions are possible and other properties added as understanding and technology improves.

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TECHNICAL MEETINGS CALENDAR

1961 REGIONAL TECHNICAL CONFERENCES (RETEC)

September 12—Plastics for Tooling sponsored by Central Indiana Section, Hotel Severin, Indianapolis, Ind. Chairman: Eugene C. Quear, c/o Delco-Remy Division, General Motors Corp., 2401 Columbus Ave., Anderson, Ind.

October 5—Plastics Foams sponsored by Buffalo Section. Section President: William Dunmyer, c/o The Carborundum Co., Building 71-1, Buffalo Ave., Niagara Falls, N. Y.

October 25—Plastics in Major Household Appliances sponsored by Kentuckiana Section, Monogram Hall, Appliance Park, Louisville, Ky, Chairman: Ray E. Eshenaur, c/o General Electric Company, AP-5-249, Appliance Park, Louisville, Ky.

November 2-3—Plastics in Packaging and SPE Southwestern Packaging Exhibition on November 1, 2, 3. RETEC sponsored by North Texas Section and Exhibition by Section with cooperation of Southwestern Division Chapter, Society of Packaging and Handling Engineers, Sheraton-Dallas Hotel, Dallas, Tex. Chairman: Peter W. Kent, 3637 Mid Pines Drive, Dallas 29, Texas.

November 15—Vinyl Plastics in the Household sponsored by New York Section with cooperation of Vinyl Plastics PAG, Statler Hilton Hotel, New York, N.Y. Chairman: Saul Gobstein, c/o Ferro Chemical Co., Box 607, Emerson, N. J.

December 1—Plastics Screw Injection Molding sponsored by Cleveland Section, Cleveland Engineering Society Building, Cleveland, Ohio. Chairman: Edward J. Haskins, c/o Injection Molders Supply Co., 17601 South Miles Road, Cleveland 28, Ohio.

Offers of papers for presentation at these Regional Technical Conferences are invited. Please address offers to RETEC Chairman or Section President.

ANNUAL TECHNICAL CONFERENCES (ANTEC)

January 30-February 2, 1962—18th ANTEC, Penn-Sheraton Hotel, Pittsburgh, Pa. Sponsored by Pittsburgh Section. General Chairman: John E. Parks, H.P.M. Division, Koehring Co., 512 Empire Building, Pittsburgh 22, Pa.

January 22-25, 1963—19th ANTEC, Ambassador Hotel, Los Angeles, California. Sponsored by Southern California Section. General Chairman: A. R. Tucker, Jr., c/o Dow Chemical Co., 900 Wilshire Blvd., Los Angeles 17, Calif.

January 28-31, 1964—20th ANTEC, Chalfonte-Haddon Hall, Atlantic City, N. J. Sponsored by Philadelphia Section. For information write Executive Secretary Thomas A. Bissell, Society of Plastics Engineers, Inc.

January 18-22, 1965—21st ANTEC, Boston, Mass. Sponsored by Eastern New England Section. For information write Executive Secretary Thomas A. Bissell, Society of Plastics Engineers, Inc.

ACS MEETING

September 3-8, 1961—140th National Meeting of the American Chemical Society, Chicago, Ill.

SPI

October 12-13, 1961—Conference Sponsored by New England Section, SPI, Wentworth - by - the - Sea, Portsmouth, N. H.

EXPOSITION

October 17-19, 1961—The First Plastics Show of Canada, Automotive Building, CNE, Toronto.

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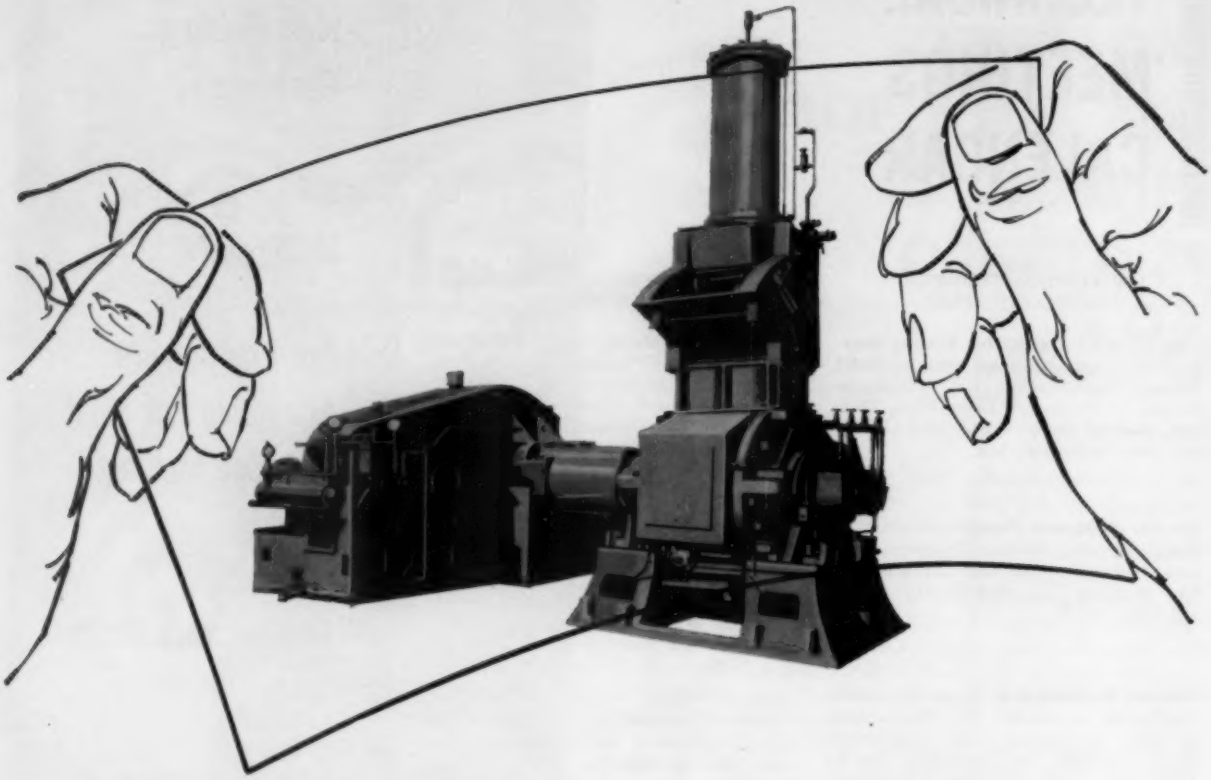

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*Signatures of SPE Credentials Committee. 2 Required

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Technical education and the holding of a degree are NOT necessary to qualify for membership, however credit will be given on the following basis in lieu of, and in addition to qualifying experience: Doctorate in technical subject—5 years; Master in technical subject—4 years; Other in technical subject—3 years; Other in non-technical subject—2 years.

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Explain in detail, the nature of your work and responsibilities. (Attach separate sheet, if necessary) _____

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→ In the space below, supply complete record of past connections in detail. Describe duties fully and state briefly any important engineering work you have done. If space is not sufficient, continue record on separate sheet of same size. Your proper classification depends greatly upon the clarity of your record of experience in plastics and the degree of technical knowledge or skill required.

DATES	NAME AND ADDRESS OF COMPANY	TITLE or POSITION	RESPONSIBILITIES

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* Fee must accompany the Application. Dues will be billed upon election.

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Held, Edward C.
Hodge, Ray
Jones, R. Vernon
Kerr, J. Wendell
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Kraft, Donald L.
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Lewis, Jimmy D.
Lilly, Major A.
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Martinovich, Robert J.
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Osborn, Charles W.
Perry, Dan E.
Peters, Donald L.
Poindexter, John W.
Porter, Ralph V.
Pourchot, Melvin E.
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Roark, Jack T.
Robbins, Archie L.
Roetzschke, Ron C.
Rush, Elton E.
Scott, John N.
Sears, Jr., Harold T.
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Sneary, L. Dean
Solop, Eli
Spillman, James V.
Stratton, Alan W.
Terry, Billy W.
Toups, Edward C.
Walters, A. L.
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Welty, Richard O.
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Cialdella, Cataldo
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Leone, Leonard H.
Leve, Kenneth M.
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Losito, Joseph M.
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Lovell, Frederick
Maj, Alfred A.
Mann, Ralph
Markowski, Henry J.
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Miller, Robert W.
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Moore, Kenneth G.
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Nathan, Jerome H.
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Shuman, Hyman
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Thweatt, Hardin D.
Tierney, Joseph W.
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Connell, John J.
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Weston, Keith A.
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Rink, Kenneth S.
Ross, Wallace B.
Rothschild, Paul H.
Ruhe, Frederick E.
Schmidt, Gustav A.
Shirk, Raymond A.
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Varnum, Robert E.
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Cain, W. E.
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Mann, Robert L.
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Onslor, Earl C.
Pearce, Stanbury
Rackett, William D.
Roop, Nathan W.
Russell, Samuel M.
Rutherford, John B.
Sanders, Robert E.
Shalett, Norman J.
Sharpe, Richard B.
Shaw, Fred B. Jr.
Shaw, Victor S.
Smith, Arthur L.
Snyder, Eugene H.
Steinberg, Albert H.
Stockton, Richard E.
Thompson, Elmer G.
Tope, Raymond S.
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Welker, Lloyd M., Sr.
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Whittaker, John K.
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Anderson, Everett L.
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Andrews, Nickolas P.
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Brandt, Herman W.
Brandt, Robert
Brandt, Robert W.
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Brown, Richard T.
Brown, Wallace H.
Brown, William Frederick
Bryan, Albert
Buckman, Charles
Buechele, John E.
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Fischer, Andrew J.
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Freeman, Hans
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Georgi, Walter
Geraghty, Thomas
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Hamilton, Walter C.
Hanan, William A.
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Ketchum, David V.
King, Harry R.
Kingstone, Forbes E.
Kinsley, John P.
Klopstock, Paul., Jr.
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Knell, L. W.
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Lane, Reginald W.
Lang, Norman
Laurin, David E.
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Levi, Kurt L.
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Mathias, Brian A.
Martin, Edwin W.
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McDougall, Edward S.
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McEwen, James Eric
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Meadham, William E.
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Merszei, Zoltan
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Miller, Henri J.
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Montgomery, Herbert Charles
Morrison, John
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Nelson, Reginald E.
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Orr, Fred J.
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Pavanel, John Charles
Pawson, George A.
Pearson, Earl L., Jr.
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Power, C. James
Prince, Ross T.
Pullan, Emanuel M.
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Pym, John A.
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Helm, Richard M.
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Isenson, Hyman
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Kelley, Frank M.
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Kocay, Alphonse S.
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Kushnerick, John P.
Kutsch, Howard J.
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Latimer, Paul R., Jr.
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Lee, Thomas O., Jr.
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Lewis, Bruce L.
Lewis, Gordon H.
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Giorgi, Achille C.
Godfrey, George J.
Godley, Philip
Goldrosen, David
Goldrosen, Louis I.
Goodman, Leonard
Gordon, Carl H.
Gordon, Everett R.
Gordon, Melvin P.
Gordon, Saul
Gottesman, Morris
Goulet, Fernando
Graham, Bertram E.
Grimaldi, Albert A.
Harrington, Richard H.
Heinig, Paul R.
Hinkley, Howard W.
Hitov, Joseph J.
Howe, Richard H.
Howe, Robert F.
Iacaboni, Michael
Jaffe, Maurice H.
Jakubowicz, Frank J.
Jobin, James E.
Johnson, Gordon Paul
Johnson, Philip M.
Johnston, James R.
Jones, Dennis H.
Kaplan, Clifford F.
Kavanagh, John A.
Kavesh, Sheldon
Kodys, Edmund
La Belle, John W.
Lacouture, Vincent W.
Lafferty, Gerald F.
Lantinen, Albert J.
Lanza, Albert P.
Lanza, Julian J.
Lauer, Keith W.
Lawton, William R.
Leary, Richard E.
Leclerc, Raymond W.
Lee, Richard A.
Lee, Richard M.
Leo, John P.
Levine, Morton
Lewis, Robert E.
Liackos, Stephen N.
Lolli, Ralph, Jr.
Lorenz, Albert J.
Larie, David R.
Mahan, Daniel R.
Mahan, Philip J.
Malerba, Everett M.
Mammone, John D.
Markham, James P.
Martino, Samuel
Mattson, Irving O. H.
Mazmanian, Joseph A.
McFadden, Dudley E., Jr.
McGivney, Neil H.
McIntyre, Albert R.
McIntyre, Frederick W., Jr.
McNaughton, Thomas W.
Metzler, Robert J.
Michaud, Raymond W.
Michel, Kenneth G.
Mitchell, Homer E.
Montagna, Leo J.
Morgan, Bertram S.
Morris, John K.
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Nichols, Anthony
Nicholson, Haldie H.
Nickerson, J. Arnold
Nolan, Joseph E.
Olson, Harry A.
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Orsage, Richard L.

Paquette, Charles J.
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Pickering, George E.
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Powers, Richard L.
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Redpath, James D.
Robbins, William G.
Rohn, Abbot M.
Root, Andrew A.
Rosis, Constantine
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Ruderman, Edward M.
Ruderman, Theodore H.
Russo, John R.
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Salvatore, Guido
Schreiter, F. R.
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Serafini, Rosario J.
Shanaf, Ernest S.
Sheftel, Milton S.
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Smith, William E.
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Wechsler, Harry C.
Weeks, Wilmot L.
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Shoemaker, William E.
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Giguere, Rolland
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Lainesse, Bruno
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Shepherd, Robert F.
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Storey, James
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Vasarhelyi, I. A.
Vaughan, Robert W.
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Collins, Jr., Herbert B.
Collins, Richard G.
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Eagland, Waldo B.
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Fisher, David
Fogg, Jack E.
Forbes, Charles H.
Franks, Theodore
Fries, Earl C.
Frizelle, William G.
Furman, Mayron
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Gebhardt, Helmut A.
Glueck, Raymond M.
Gnelin, Elmer F.
Goral, Ernest W.
Gignac, G. Michael, Jr.
Grabowski, Joseph
Grapensteter, Jack F.
Grenci, Dominic A.
Gysel, Henry J.
Hamel, Lewis E.
Hammond, John E.
Hanley, Thomas G.
Hanselman, Eugene F.
Hanaford, Van Buren N.
Harrington, Norman F.
Hayes, Leo J.
Hayes, Richard L.
Hayslip, George A.
Hecht, Marco
Heier, Robert J.
Henze, Edward D.
Hess, Richard G.
Hill, George R.
Hill, Howard J.
Horton, William H.
Horwitch, Harry
Howe, Vernon M.
Hultberg, John A.
Hungerford, George P.
John, Frederick W.
Johnson, David E.
Kaempffee, Frederick A.
Kahn, Harry A.
Katus, G. A.
Kayser, Emil J.
Kiely, Robert R.
Kincaid, Joseph R.
Kluth, Lewis A.
Kneeney, A. Mervin, Jr.
Knox, Harry E. Jr.
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Kruse, Raymond W.
Lannin, David W.
Lander, Raymond A., Jr.
Lannin, David W.
Leghorn, Kenneth M.
Lehman, Richard A.
Lennon, Charles F.
Levine, Charles J.
Lippa, Fred F.
Lyons, Terrence W.
Manucci, Ronald F.
Matteson, Floyd E.
Meagher, John A.
Melville, Richard J.
Messenger, David L.
Meyer, Garson
Meyer, Werner T.
Mueller, William J.
Neward, George A.
Newman, James B., Jr.
O'Brien, David C.
Obstfield, Fredric A.
O'Hearn, Joseph J.
Osborn, Paul V., Jr.
Palmer, Edwin F.
Park, Richard G.
Peet, David R.
Perry, Rodney S.
Pieper, Emil J.
Powell, John P.
Prall, Geo. M.
Redmond, Floyd
Rosik, Burt
Rowe, Wilfrid, Jr.
St. John, Randolph
Selldorff, John T.
Serrell, Victor E.
Shanley, Leo W.
Simpson, Theodore B.
Smith, Robert D.
Smith, Roy S., Jr.
Spencer, Arthur W.
Spitznagel, John F.
Squire, Albert T.
Steele, Harry V.
Steiner, Robert H.
Strand, Donald J.
Stroman, Robert M.
Szelwach, Edward E.
Tchejeyan, Sarkis K.
Tseng, Yung-Sen
Tullar, Dudley D.
Turrell, Merton R.
Tyrrell, Frederick S.
Ulmschneider, Lawerence A.
Ulsop, Alfred P.
Uttaro, Eugene R.
Van Epps, Clarence F.
Venturelli, Vincent S.
Vivian, Harold F.
Vollertsen, John J.
Wahl, Joseph H.
Walpert, George W.
Wargo, Lewis L.
Wells, Howard F.
Wells, Walter H.

Wenskus, Jr., James J.
White, Allen W.
Williams, Charles J.
Williams, Robert F.
Winding, Charles C.
Wing, C. Burton
Wolcott, Donald F.
Woodruff, John H.
Zelnick, David R.
Zink, Norbert G.

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Butcher, Bert B.
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Cone, Irwin C.
Cooper, Thomas H.
Crawford, Richard H.
Dart, Peter W.
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Gindre, Andre C.
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Hibbard, Dean
Hiza, Michael J., Jr.
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McCusker, James A.
Millard, Raymond L.
Newmann, Thomas J.
Newman, David E.
Nickel, Donavon Dale
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Robb, Wayne F.
Sacry, Paul A., Jr.
Slone, Murray C.
Smallwood, Walter B., Jr.
Stanley, William T.
Taplin, Thomas E.
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ST. LOUIS

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Bowman, William G.
Brannaker, Edward W.
Brimer, Marvin J.
Bub, Jr., Leo J.
Bufka, Vernon A.
Burd, Wayne D.
Bussart, Walter P.
Butler, Joe N.
Christensen, M. L.
Clark, C. Todd
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Coons, Bennett M.
Cope, Dwight W.
Craver, J. K.
Cronkhite, Paul W.
Czabi, Menyhert
Cutlip, Claude R.
Darby, Joseph R.
De Camp, Wayne
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Dirkers, Harold L.
Evitts, Lloyd L.
Fenner, Roger H.
Fenner, Otto H.
Fink, Miller H.
Fisler, Royal E.
Fox, Jr., Cyril B.
Frantz, Charles H.
Gahagan, Stewart W.
Goessling, John G.
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Grossman, Jack
Hagemeyer, Charles F.
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Hanrahan, Paul B.
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Chenes, Charles D.
Clancy, Joseph F.
Clark, Henry D., Jr.
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Caddy, Thomas
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Golden, Harold R.
Gould, William S.
Graham, Bertram A.
Griefelt, Gunther H.
Hall, Keith W.
Hart, James R.
Hartkopf, Rudolf
Hofmann, Victor E.
Hoover, Louis P.
Hoppens, Harold A.
Hyland, James W., Jr.
Jex, Horatio N.
Kassay, Andrew W.
Keiser, Darwyn M.
Kohler, Carl E.
Kohler, Erik
Kramer, William
Lindsay, Stanley C.
Lowry, William J.
Lucius, Clair J.
MacArthur, Hamilton E.
Mattimoe, Paul T.
McHue, Leo T.
Miller, Frank E., Jr.
Minnick, Gerald D.
Mohr, J. Gilbert
Mona, John
Moylan, James J.
Nazar, A. R.
Phillips, Lewis L.
Pickering, Russell, J.
Pioch, Herbert W.
Pioch, Lawrence A.
Plymale, Charles E.
Purdue, John C.
Rathke, Philip P.
Rea, William H.
Rex, Raymond H.
Rosny, Edward J.
Rosenberger, Frank B.
Ryan, Joseph D.
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Scalora, Anthony J.
Scarvelis, G. S.
Schmid, William
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Seislove, Richard W.
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Sicha, Theodore F.
Skinner, James F.
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Smith, Robert M.
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Logozzo, William A.
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Mc Laughlan T. R.
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Means, Frederic C.
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Moody, Arthur F.
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Oldham, Wilbur N.
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Pinsky, Jules
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Purdy, Arthur M.
Raiche, Arthur J.
Rath, Paul S.
Raymond, Sumner W.
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Richter, Sven
Richter, Winston H.
Ringel, Samuel
Rittenhouse, William E.
Roberts, C. Kenard
Robison, C. Forbes
Rogler, Jr., William C.
Rohlfing, Ralph W.
Roman, Harold G.
Roman, Michael J.
Roselund, Victor E.
Rump, John H.
Ruth, Robert R.
Sackett, Robert D.
Sampson, Arthur J.
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Schneider, Albert J.
Schnitzer, Herbert S.
Schupp, Ralph J.
Schwarz, Francis J.
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Seifert, Walter O.
Shannon, Lawrence F.
Shaw, Alexander D., III
Shay, John J.
Sheedy, Thomas J.
Sherman, Jay D.
Sherman, Robert W.
Shumaman, Albert W.
Shusman, Tevis
Shwayka, Walter W.
Silverstein, S. W.
Sloat, John E.
Slotchia, Ira
Smith, George D.
Spiwak, Larry
Sprankle, Cortes N.
Stabler, Robert E.
Staff, Arthur A.
Stahlberg, Eric
Stahlberg, Paul
Starr, II, John J.
Stickel, Wesley N.
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Strauss, Robert G.
Sumner, Kingsley E.
Sweeney, Edward J.
Sweeney, Lawrence A.
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Tiley, Raymond A.
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Trembley, John F.
Tradeau, Rolland C.
Tyson, Robert M.
Usko, Alexander J.
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Veazey, Earl W.
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Wallace, Lewis C.
Watson, Donald A.
Webb, Kermit M.
Webber, James B.
Welch, William E.
West, Joseph K.
Wheeler, Clifford R.
Wheeler, Leonard
Whitaker, Lawrence W.
Whitehead, George W.
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Will, Alphonse E.
Wilson, Wilfred K.
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Wood, Donald N.
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Kaldor, Ervin
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Wright, John M.
Wright, Paul J.
Wymore, Alvin C.
Yeshin, Leon
Zeekaf, J. G. M. E. H.
Zeigen, Victor D.
Zimbaum, Samuel D.
Zonew, Stefan

Alphabetical Roster of the Membership

Key to Section Listings

AK	- Akron	NS	- Non Section
ARIZ	- Arizona	NT	- North Texas
B-W	- Baltimore-Washington	NI	- Northern Indiana
B-T	- Bartlesville-Tulsa	NWP	- Northwest Pennsylvania
BI	- Binghamton	ONT	- Ontario
BUF	- Buffalo	OSA	- Osaka (Japan)
CI	- Central Indiana	PNW	- Pacific Northwest
CNY	- Central New York	PH	- Philadelphia
CO	- Central Ohio	PV	- Pioneer Valley
CHI	- Chicago	PI	- Pittsburgh
CLEV	- Cleveland	QUE	- Quebec
CT	- Connecticut	RO	- Rochester
DET	- Detroit	RM	- Rocky Mountain
ENE	- Eastern New England	SL	- St. Louis
FLA	- Florida	ST	- South Texas
GG	- Golden Gate	SNE	- Southeastern New England
KC	- Kansas City	SEO	- Southeastern Ohio
KI	- Kentuckiana	SS	- Southern
MV	- Miami Valley	SC	- Southern California
MIL	- Milwaukee	TOL	- Toledo
MONT	- Monterrey (Mexico)	TRI	- Tri-State
NWK	- Newark	UMW	- Upper Midwest
NY	- New York	WNE	- Western New England

A

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IBM, Owego Federal Systems Div., Owego, N.Y.

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ZOLMAN, GEORGE R. Techn TOL
Libbey-Owens-Ford Glass Co., Research, 1701 E. Broadway, Toledo 5, Ohio

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ZONEW, STEFAN ChfEngr N-S
Conticca Engineering, Av. Santa Rita, Ed. Mica, Maracaibo, Venezuela, S. A. mail: Av. 3H No 72-45 Ed. Alexander, 20 Piso Maracaibo, Venezuela, S. A.

ZRADA, WALTER T. Foreman NWK
Plastic Extruded Prod., 308 Port Ave., Elizabeth, N.J. mail: 33 Maple St., Edison Twsp., Nixon, N.J.

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Bakelite De Mexico, S. A. 534 M. Escobedo, Mexico DF5, Mexico

ZUBRIN, DAVID Pres DET
Dale Plastics Corp., 5736 12th St., Detroit 8, Mich., mail: 24650 Radcliff, Oak Park 37, Mich.

ZUKOR, LEE J. EngrgEditor NY
Plastics Technology, 630 3rd Ave., New York 17, N. Y.

ZUKOWSKI, EDWARD A. ProcEngr NWK
Celanese Plastics Co., mail: 16 Sunnyside Terrace, E. Orange, N.J.

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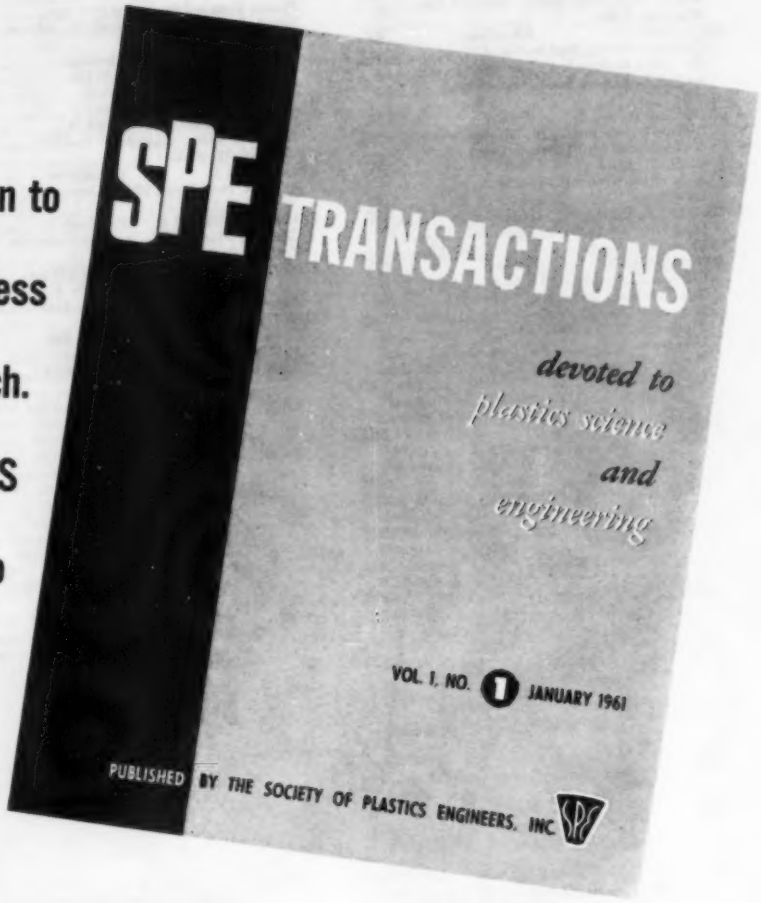

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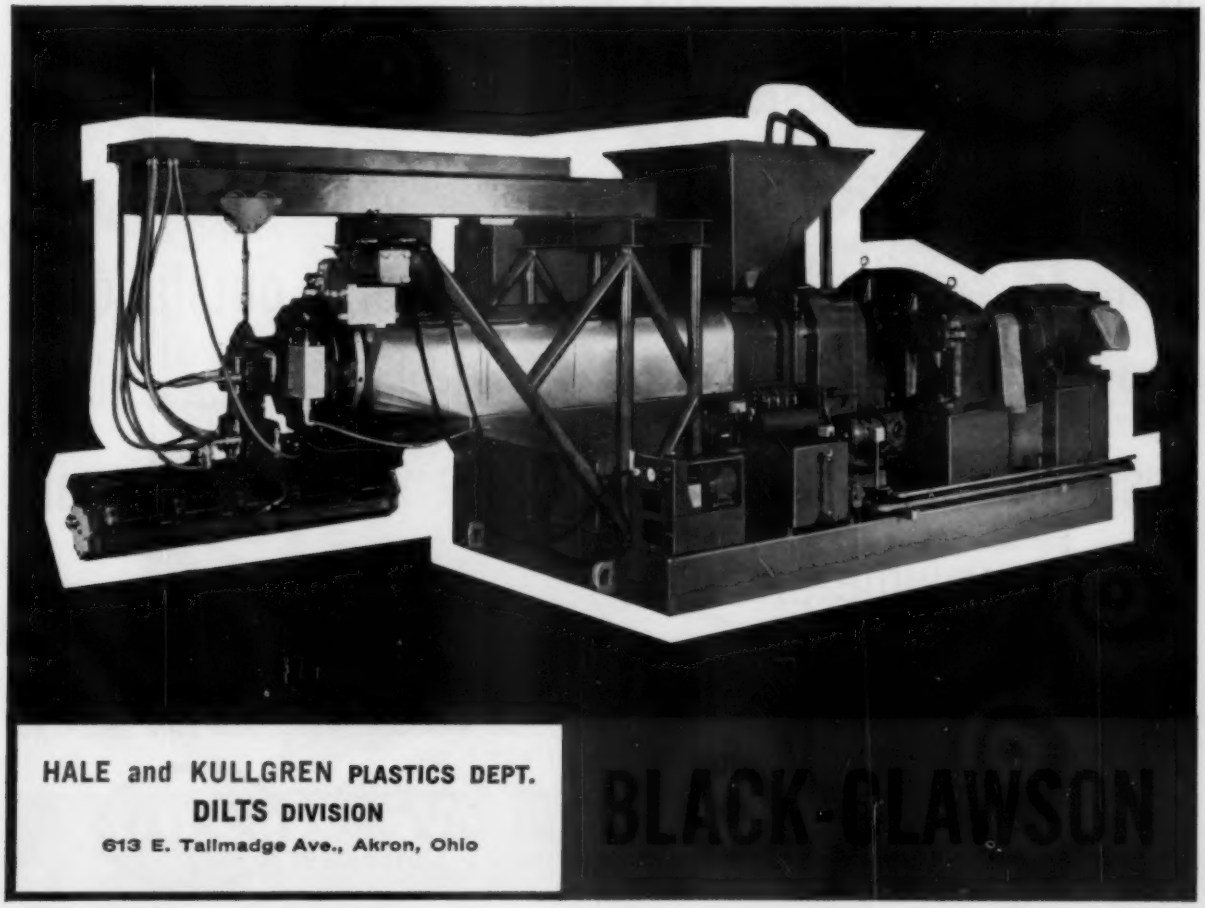

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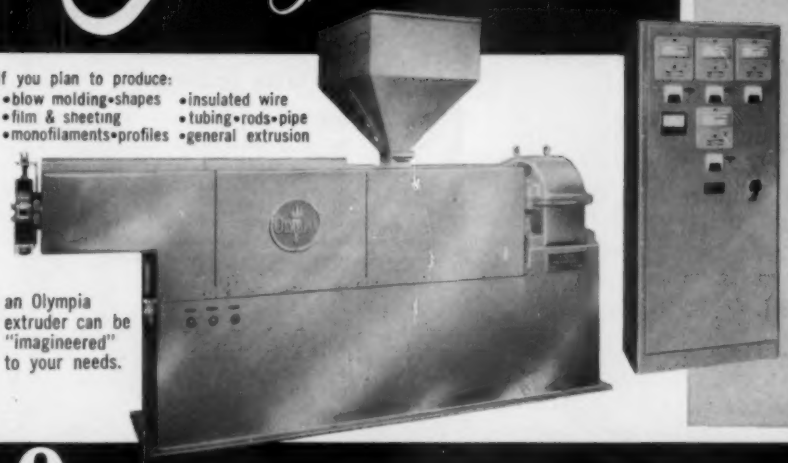

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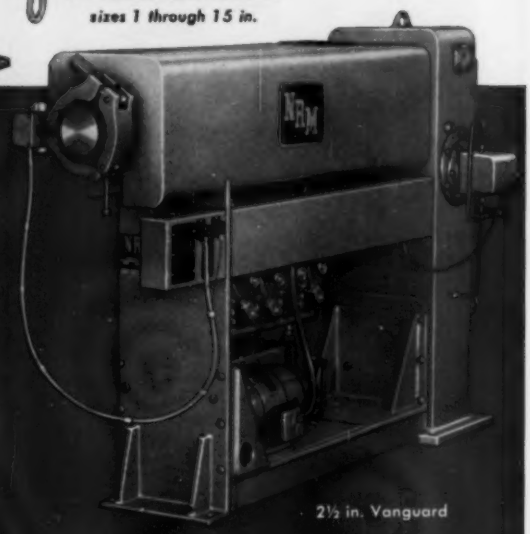

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SECTION NEWS

Golden Gate

Present Market Development of Rigid Urethane Foams

MIKE RABIN
(Transparent Products Corp.)

The Golden Gate section met on May 25, 1961, at the International Inn. Mr. Brant Newsom, president, introduced the guest speaker of the evening, Roger Jennings of Polytron Corp., Richmond, California.

Mr. Jennings stated that in the last five years the growth of foam materials has been over 200% per year. The biggest market at this time in flexible foam, is the seat cushioning for automobiles and home furnishings. Rigid foams are coming into use as insulation in cold storage, such as freezer plants and commercial and domestic refrigerators. There is a future outlook for approximately one and one-half billion pounds yearly on same.

New Officers Introduced at June Meeting

Outgoing president, Brant Newsom, introduced the Section's new officers: G. R. Mallory, Kimball Mfg., Co., President; Robert Hughes, Industrial Plastics and Chemicals, Vice-President; John Joyce, Western Plastics, Secretary; Ted Malliani, San Francisco Plastics, Treasurer; James C. Smith, Reichhold Chemicals, Inc., National Director. New Members of the Board include: G. R. Mallory, Frank Hunt, John Joyce, John Rogers, and Ted Malliani.

Program Chairman, Al Costantin, narrated a color film, "Project Mercury—Progress Report No. 2", concluding the Section's business until the Fall.

Philadelphia

New Officers Elected

GEORGE R. de HOFF
(E. I. du Pont de Nemours & Co., Inc.)

At the May 23 meeting of the Philadelphia Section, retiring President Bob Conwell introduced the new officers of the Section: Ernest G. Schwab of Union Carbide Plastics Company, President; George E. Davis, Electric Storage Battery Company, Vice President; Robert Peterson, E. I. du Pont de Nemours & Company, Secretary and James Hiltner, Rohm & Haas Company, Treasurer.

The program for the last formal session of the 1960-61 season was Industrial Blow Molding. Chairman James Almoney introduced C. A. Joslin of Union Carbide Plastics Company who discussed the various types of blow molding processes, the functional advantages of blow molding and several industrial applications. Then L. C. Morehouse of F. J. Stokes Company and G. F. Kirkpatrick of Union Carbide Plastics Company joined Mr. Joslin in an interesting question and answer session.

Central Ohio

Decorating and Marking of Plastics

RICHARD B. SHARPE
(Westinghouse Electric Corporation)

On May 16, the Central Ohio Section heard an interesting and well-presented program about "Decorating and Marking Plastics" given by Mr. E. E. McQueen of General Roll Leaf Manufacturing Company. He discussed hot stamping—its possibilities and its pitfalls. He described the construction, theory of adhesion, and methods of application of both pigmented and metallized hot stamping foil. He stated that of all the materials that are hot stamped such as wood, paper and leather, plastics undoubtedly cause the most problems. High density polyethylene is among the easiest and polypropylene the most difficult to hot stamp.

Miami Valley

Officers Installed at Picnic

ROGER A. HOUSTON
(Recto Molded Products, Inc.)

Competing for a dozen golf prizes, 33 of the 60 attending members at the annual party enjoyed a "day off" on June 16 at the Elks Country Club in Hamilton, Ohio. Dick Rieger, representing Union Carbide Plastics Co., presented the most "imposing trophy" established as an annual prize to the best company twosome, to Dr. George Goepfert and Dr. I. Hechenbleikner, Cincinnati Milling Machine Co.

Following dinner, the officers for the coming year were installed as follows: Dr. George J. Goepfert, Cincinnati Milling Machine Co., President; William D. Evans, Estee Mold Co., Vice President; Richard H. Rieger, Union Carbide Co., Secretary; and Richard W. Syday, Inland Div., General Motors, Treasurer.

Southern California

May, June, Meeting Talks Cover Wide Scope

JOHN A. STAHMANN
(Rocketdyne, A Div. of N. American Aviation)

The May and June meetings of the Southern California Section spanned a variety of topics handled through panels and talks. Mr. Ronald R. Anderson, Plastics Field Development Engineer, Dow Chemical Co., Plastics Technical Service-West of Torrance, Calif., discussed pertinent properties and applications for the rigid polystyrene foam and flexible type polyethylene foam. Mr. Joe Slapnik, Technical Service Representative, Koppers Co., Plastics Division, Los Angeles, compared molding of expandable polystyrene with injection molding to demonstrate that as a commercial product, it is no more or less difficult to understand, process or sell than conventional materials.

In June, Mr. J. P. Sterry, Manager, Materials Research Division, H. I. Thompson Fiber Glass Co., Los Angeles, described current usage and trends for high-temperature, reinforced plastics in aerospace applications.

Officers elected for the 1961-62 season were introduced. They are: Samuel Silberkraus, President; Harold B. Kotkin, Vice President; Paul Metzger, Secretary; Kenneth Cressy, Treasurer.

Rochester

"Polypropylene" Discussion Closes Season's Meetings

JOHN T. BENT
(Eastman Chemical Products)

The final meeting of the 1960-61 season was held June 15 at Logans with over 60 members present. Mr. Theodore Kresser, Senior Staff Member of the Plastics Technical Problems of Spencer Chemical, spoke on Polypropylene.

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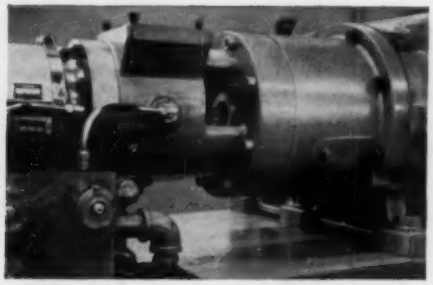

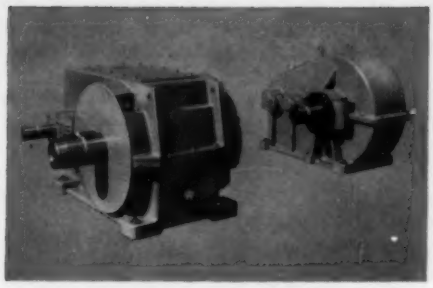

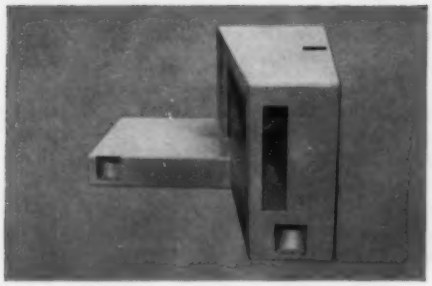

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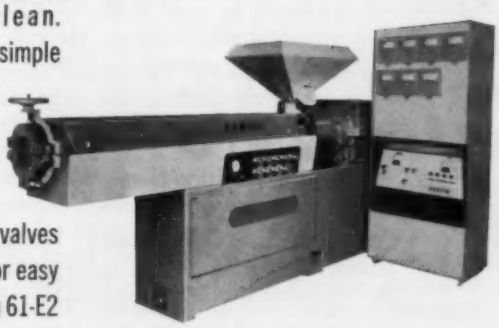

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ABOUT MEMBERS

Celanese International Corporation has added **Dr. Howard L. Pilat** to its staff in the capacity of assistant vice-president. Dr. Pilat has been manager of market development for Celanese Plastics and Polymers after having been in charge of new product development. He holds a B.S. from the University of Oklahoma and a Ph.D from the University of Pittsburgh where he was a lecturer in organic chemistry.

William J. Dewar, who has been presented with the Western Plastics Award given in recognition for outstanding services to the industry, is technical director of Furane Plastics. The 1956 award was presented to John Delmonte, also of Furane.

Dr. Cyrus H. Thomas market development engineer has recently edited "Plastics—A New Dimension in Building" which was published by the Plastics in Building PAG. Dr. Thomas who received his B.S. and Ph.D from the Georgia Institute of Technology was with Esso before joining Enjay in 1956.

Gerald F. Bamberger has recently assumed the vice-presidency of a newly combined organization, the result of a merger between Interplastics Corp., Jackson Heights, N. Y., and George Woloch Co., Inc., New York City. Specializing in the supply of raw materials and molding powders for the thermoplastics industry, the company will operate from New York offices with branches and warehouses at several other locations under the name, George Woloch & Co.

A new award for the outstanding student in freshman chemistry, to be known as the **Raymond B. Seymour** award has been established by the Xi Alpha chapter of Gamma Sigma Epsilon at Sul Ross State College. Dr. Seymour a B.S. graduate of the University of New Hampshire obtained his Ph.D from the University of Iowa in 1937, and is now head of the department of chemistry at Sul Ross.

The appointment of **Clinton J. Starke** as central district sales manager of the Dapon Department of Food Machinery and Chemical Co., has been announced. He was formerly engaged in decorative lamination at the applications technical service laboratory in Baltimore. Mr. Starke, a professional engineer who was formerly with the laminate products department of General Electric, is a graduate of the University of Missouri.

Dr. Edward T. Severs has recently been promoted to the position of technical manager at Spencer Chemical Co. Engaged in technical product development and marketing work since 1937, he received his doctorate in Chemical Engineering, University of Delaware.

The Plastics Division of Koppers has moved up two society members. **R. F. Seubert** former manager of applications laboratory is now manager of product development and **J. G. Pick** formerly manager of the Technical Laboratory has succeeded him. Mr. Seubert who holds a Chemical Engineering degree from the University of Cincinnati joined Koppers in 1942 with the former Tar and Chemical Division. Mr. Pick, a graduate of Pennsylvania State, entered Koppers in 1948 as a chemist in the old Chemical Division.

The Kordite Co. has named **George L. Fearnley, Jr.** manager of its new plastics manufacturing facilities in Tyler, Texas. Succeeding him as plant manager in Macedon, N. Y. is **Melvin S. Cagen**. Mr. Cagen has been on Kordite's technical staff since 1957 as project manager, manager of semi-commercial operations and plant technical superintendent. The company also made known the appointment of **Dwight Clark** as technical superintendent.

John M. Lees has been elected President of the Ontario Section. He is with Canadian General Electric.

W. Pat Fralia recently announced the formation of the W. Pat Fralia Co., P.O.B. 12253 Fort Worth, Texas. He will act as a manufacturers representative for leading component and instrument companies. Mr. Fralia a Texas University graduate, claims that his experience in electronics, plastics and electrical design will be valuable to companies in the electronics field.

Narmco Materials Division has introduced **John J. Mobilia, Jr.**, as new area technical sales representative. Mr. Mobilia has experience in the fields of structural adhesives, reinforced plastic laminates, potting, encapsulating and coating compounds, sandwich type structures, molding compounds and abrasive materials.

The United Plastics and Distributors Association held its sixth annual meeting in New York on June 8-9. Present were **August H. Metz**, general manager, Commercial Plastics and Supply Corporation; **Bradford L. Nicholson**, president, Sepsco Inc., who moderated a panel discussion on Industry Distribution Policies and Practices; **George H. Lightfounder** of Modern Plastics and vice president of United Plastics Distributors Association.

Henry E. Dutot, a sales representative for the Plastics & Resins Divisions of American Cyanamid Co. in the Cleveland area has been elected President of the Cleveland Section, SPE. He has served as Vice-President and is the founder and editor of the "SPEC Sheet", the monthly newspaper of the Section.

Foster J. Young, manager of polymer applications research, the Goodyear Tire & Rubber Co., takes over the gavel as President of the Akron Section, SPE. **Merle Sanger**, head of cellular materials development for the company becomes Vice President; **Don F. Siddall**, director of Kent Laboratories at Kent, Ohio, Secretary, and **R. K. Senn**, general manager of extruder sales, National Rubber Machinery Co., Treasurer.

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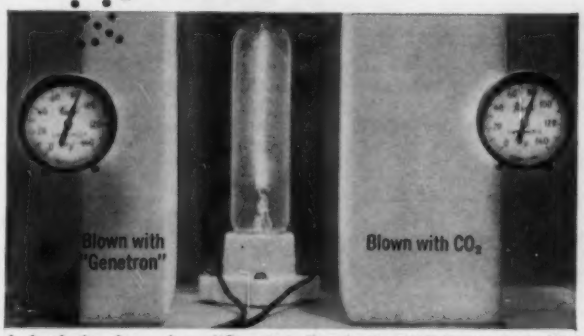
of urethane *rigid* foams by *half!*



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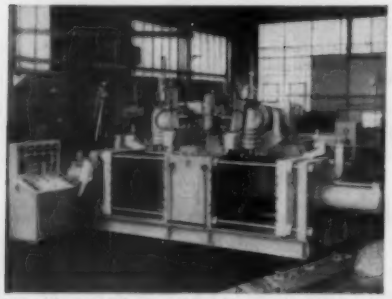
Packaging Notes

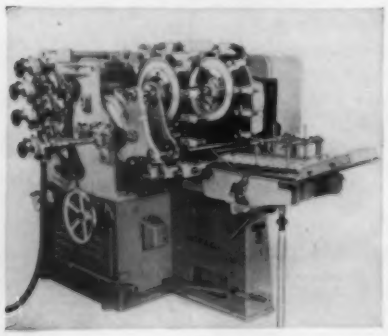
Pressure-sensitive polyethylene tape sustains its tack and flexibility throughout a temperature range of -50° F to 225° F. It's stretchable, conforms to most surfaces to which it is applied, resists water and many chemicals. The bond between the permanent adhesive backing and the four-mil polyethylene surface is said to be excellent. Potential applications of the new, high-tack tape include freezer packaging, closure and sealing of plastic covers and liners, drums and bags.

Giant blow molding equipment turns out thin-wall drum liners of polyethylene at the rate of 120 to 150 per hour. The two-station prototype illustrated has produced containers up to 80 gallons in capacity; is considered capable of blowing objects twice the size without difficulty. Molds operate alternately.



New blow molding machine has produced objects 15 to 80 gallons in size, including 55-gallon drum liners made of U.S.I.'s PETROTHENE 106 polyethylene resin.

Automatic bottle printing machine developed in Switzerland is now being distributed in the U. S. It prints in dry offset—up to four colors in a single operation. Handles cylindrical polyethylene bottles with a diameter range of one to four inches and a printing length of 8¼ inches; or, bottles up to approximately five inches in diameter without printing the whole circumference. Maximum output: 2500 per hour.



U. S. I. Predicts New FDA Ruling Will Spur Food Packaging Use Of Polyethylene

Broader Acceptance of Film, Laminates and Molded Containers Anticipated

The Food and Drug Administration's recent approval of specification-grade polyethylene for food packaging is expected to result in significantly greater use of this versatile plastic. Explains William P. Marsh, Jr., Vice President and Assistant General Manager of Chemical Operations, U. S. Industrial Chemicals Co.: "Although polyethylene has been sold as a food packaging material for some time, many processors have preferred to await FDA's position before investing in development and equipment.

"With approval granted, we look to polyethylene's natural advantages to be put to substantially increased use for packaging butter, cheese, cream and other dairy products—as well as for both fresh and frozen meats. It's just the stimulus needed to spark considerably higher sales in this major market."

Mr. Marsh feels the rise in polyethylene food packaging will be immediately apparent and will have several forms: film; board, foil and cellophane laminates; molded cups; and vacuum-processed containers.

ALL U.S.I. PETROTHENE® polyethylene resins made for food packaging applications fully comply with the new FDA regulations.

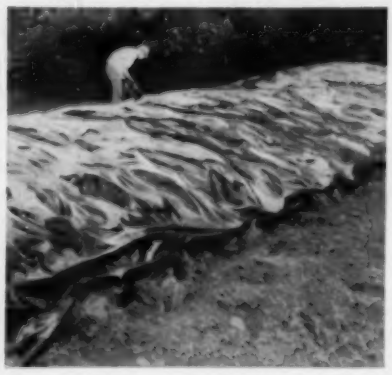
Effects of FDA's regulation approving specification-grade polyethylene as a food packaging material will soon be reflected in supermarkets across the country. Sharp rise in polyethylene-packaged meats and dairy products is foreseen.

Silage Protected by 7-mil Green Polyethylene Film

Trench and bunker silo covers of new 7-mil green polyethylene film are providing better storage conditions than upright silos—at a fraction of the cost. The green pigmentation helps ward off harmful ultraviolet sun rays and is pleasing to the eyes. Furthermore, the film guards against oxygen attack on silage nutrients and still allows for escape of excess gases which form during storing. The 7-mil thickness provides strength for serviceability and long life.

U.S.I.'s PETROTHENE polyethylene is used in the production of the covers. Explains the manufacturer: ". . . because no weak spots can be tolerated, we insist on resins of utmost reliability and uniformity."

The new film is also being used as ice rink liners and swimming pool covers.



Improved Mold Decorating Process Developed

Look for a new look in molded polyethylene products. A Youngstown, Ohio company reports a unique process said to make it possible to decorate even deep cavities of molds in almost any pattern of grain desired.

According to the announcement, "practically any design that can be drawn in line" can now be incorporated in either cavity and core molds for injection and blow molding or in dies for compression molding. To date the method has been used for houseware, automotive, TV and radio products.

Advantages claimed for decorating molded products: increases sales appeal; provides a durable, mar-resistant finish; offers functional improvements and economies to molders — such as air release for blow molding, etc. A lessening of static charges is also believed to result, but this has not yet been fully explored.

So that you can get the information you want in the shortest possible time, we suggest you write directly to the company address listed at the end of each new product item.

New Materials and Equipment

MATERIALS AND APPLICATIONS

Rigid Polyurethane Foam Additive

Dow Corning offers a new silicone additive named Dow Corning 113, a silicone–glycol copolymer. By promoting formation of uniform, fine-celled polyurethane, foam production should be facilitated. Stability and ease of handling are important selling points. *Dept. SPE,* **R. S. Argyle, Dow Corning Corporation, Midland, Michigan.**

Methacrylate Functional Group Monomers

Rohm and Haas now has available 2-hydroxyethyl methacrylate (HEMA) and 2-hydroxypropyl methacrylate (HPMA) in pilot plant quantities. They can be polymerized in emulsion or solution to give copolymers with reactive hydroxyl groups which in turn can be reacted to form thermosetting plastics and elastomers, especially acrylic coatings. Literature and samples from: *Dept. SPE,* **Rohm and Haas Company, Special Products Department, Phila. 5, Pa.**

Water Soluble Copolymers

The availability of vinyl ether polymers and copolymers has been announced. Sold under the name of "Gantrez", they are high-pressure acetylene derived chemicals. The first product is a methyl vinyl ether and maleic anhydride copolymer, useful in adhesive, coating, latex polymerization, cosmetic and other industrial applications. *Dept. SPE,* **The Chemical Group, General Aniline and Film Corp., 435 Hudson Street, New York 14, N. Y.**

One Shot Fire Retardant Rigid Foam

"Hetrofoam 250" created by the reaction of a polyol and a polyisocyanate is reported to be a major breakthrough in the field of rigid foam systems. Rapid and uniform rise, excellent skin bonding characteristics and rapid cure are some of the properties of this fire-retardant foam where harmful additives are not used. Write *Dept. SPE,* **Durez Plastics Division, Hooker Chemical Corp., North Tonawanda, New York.**

Sheeting Grade Polypropylene

Escon 502 and 522 are being offered by Enjay. Of melt index 0.6 they are adaptable to vacuum forming. Expected applications are where large surface areas are involved. Information and prices: *Dept. SPE,* **Enjay Chemical Company, 15 West 51 Street, N. Y. 19, N. Y.**

Flexible Phenolics

Internally plasticized permanently flexible phenolic resins are now available in commercial quantities. Flexiphen 160 is a high impact material where the normally brittle cure is overcome by the addition of methylene linkages between phenolic groups with longer hydrocarbon chains, resulting in less rigid inter-molecular bonds. The chief market is expected in molding compounds. Write *Dept. SPE,* **Specialty Chemical Sales Department, Tar Products Division, Koppers Company, Inc., Pittsburgh 19, Pa.**

Liquid Vinyl Stabilizers

Two new single-package liquid cadmium-barium zinc stabilizers have been introduced as "Metasap ABC-51 and 52". They are reported to provide better calendering, molding and extruding formulations. *Dept. SPE,* **Technical assistance, Metasap Division, Nopco Chemical Co., 60 Park Place, Newark, N. J.**

Extrusion Coating Resin

"Marlex TR-515" is a tough barrier resin with potential coating rates in excess of 600 feet per minute on standard equipment and coating weight of less than five pounds per ream. Resistance to scuff, temperature extremes, moisture and grease should be advantageous for marketing the material. *Dept. SPE,* **Phillips Chemical Co., Bartlesville, Okla.**

New Grade Polycarbonate Resin

A new grade of "Lexan" has improved clarity resulting from the use of additives masking the natural light amber colour of the resin and preventing darkness during molding. Information *Dept. SPE,* **Chemical Materials Dept. General Electric Co., Pittsfield, Mass.**

New Polyethers

"Actol" is the trade name for a new line of polyethers which purportedly give urethane foams excellent tensile compressive and aging properties. Material can be used on any commercial foam production equipment currently being used. Technical literature, *Dept. SPE–* **NA 78, Nat'l. Aniline Div., Allied Chemical Corp., 40 Rector St., N. Y. 6, N. Y.**

MANUFACTURERS' LITERATURE

Custom Molding

Chanal Plastics new brochure discusses their services in vacuum forming, pressure forming and blow molding. *Dept. SPE,* **Chanal Plastics Industries, Inc., 63-20 Austin St., Rego Park 74, N. Y.**

Header Injection Nozzles

Four-page brochure gives specifications of sixteen plastic injection machine nozzles and adaptors. *Dept. SPE,* **Header Tool Company, 24474 Telegraph Road., Southfield, Michigan.**

Ameripol Polyethylene

Goodrich-Gulf has published a 12-page brochure describing their new high density polyethylene. Physical, chemical and electrical property charts along with stress and environmental resistance comparative graphs are given. *Dept. SPE,* **Technical Bulletin No. 1, Goodrich-Gulf Chemicals, Inc., 1717 East Ninth Street, Cleveland 14, Ohio.**

Tenite Pipe Grade Formulations

Materials Bulletin No. 8 of Eastman Chemical Products gives properties and extrusion data on Tenite polyethylene pipe-grade formulations. *Dept. SPE,* **Plastics Division, Eastman Chemical Products Inc., Kingsport, Tennessee.**

Laminated Architectural Glass

Monsanto, a supplier of polyvinyl butyral interlayer (Saflex) offers a folder on methods and materials to use when installing laminated architectural glass. *Dept. SPE–***HH, Monsanto Chemical Co., Springfield 2, Mass.**

New Vacuum Deaeration

VARIABLE SHEAR RATE

4½" EXTRA-LONG FLOATING SCREW

REIFENHAUSER EXTRUDER

featuring

HIGH TORQUE GEAR REDUCER

with handy gear shift

West or Wheelco controls, standard wiring with US fuses, standard heaters, bearings, rotary unions, pressure gauges.

In addition to the floating screw control, the new 4½" Reifenhauser Extruder is available with a **high torque gear reducer and handy gear shift for instant change of the gear ratio.** Whether you need high screw speeds for a low viscosity material or low screw speed and high torque for a high viscosity material, simply use the handy gear shift and you are ready with a full 10:1 speed range for every extrusion application. **Screw sizes from 1¼" through 6"; Le/Dia. ratios 20:1 to 30:1. Packaged installations for film, sheet, monofilaments and biaxially oriented pipe.** Write for full information.

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Egan

CAST FILM UNITS

Egan Cast Film Units, available through 120" wide, include these features: highly polished, chrome-plated casting rolls with spiral baffling for uniform temperatures; specially designed air pressure chamber with adjustable assembly for controlling "frost line," and assuring uniform film contact across full face of roll; edge trimmer assembly; trim disposal system; turret type winder with electronic drive for each winding position to provide programmed tapered tension, and web cut-off and transfer at operating speeds.

A full range of Egan Extruders are also available in sizes: 2" through 12"

FRANK W. EGAN & COMPANY
SOMERVILLE, N. J.

Pressure and Vacuum Gages

A new 32-page catalog describes Honeywell's instruments for recording, measuring and indicating pressures and vacuums in industrial processes. Specifications are listed in detail. Write *Dept. SPE,* **Minneapolis-Honeywell Regulator Co., Industrial Division, Wane and Windrim Avenues, Philadelphia 44, Pa.**

Polyethylene Film Extruders

A 56-page operating manual can now be obtained. Said to provide both managers and operators with sufficient know-how to make the best film at the fastest rates, it is claimed to be a thorough compilation of sheet extrusion information. Write *Dept. SPE,* **U.S. Industrial Chemicals, Div. of National Distillers, 99 Park Ave., New York 16, N. Y.**

Peroxide Compounds

Application, shipping data, chemical and physical properties are presented in the new general bulletin on organic peroxides. Write *Dept. SPE,* **Lucidol Division, Wallace and Tiernan Incorporated, 1740 Military Road, Buffalo 5, N. Y.**

Design Procedure for Structures

An eight-page study of "Design Considerations for Applying Reinforced Plastics in the Corrosive Environments of the Process Industries". A table is presented which estimates the degradation of tensile strength in reinforced polyester laminates under 14 practical service conditions. Write *Dept. SPE,* **William T. Scott, Atlas Powder Co., Wilmington 99, Del.**

EQUIPMENT

Teflon Test Kit

Free test kit has been made available to users of molded Teflon sheet. By measuring porosity, the user will be made aware of variations in density. Send to *Dept. SPE,* **Chemplast Inc., 3 Central Ave., East Newark, N. J.**

New Vacuum Deaeration Unit

A 55-gallon unit for plastisol deaeration designed for removal of entrapped air is available. A triple action distributor affords positive removal of air pockets by exposure to vacuum. Inquire *Dept. SPE,* **Squire-Cogswell Company, 4141 North Kedzie Avenue, Chicago 18, Illinois.**

Temperature Controller

A small 22" long platinum temperature controller is now available. A resistance bulb type, it offers a choice of on-off or proportioning control over the temperature range of —150°F to 1050°F. Transistorized circuitry, plug in construction and low power requirements are additional features. Write *Dept. SPE,* **Technique Associates, Div. of Duncan Electric Co., Inc., 1413 N. Cornell, Indianapolis 2, Indiana.**

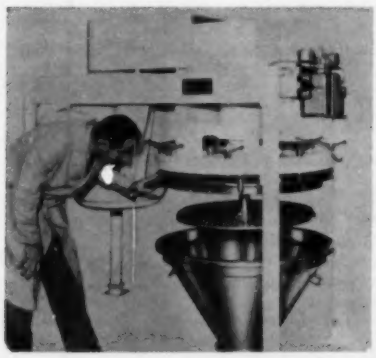
Intermediate-Size Molding Machine

Dry cycles of 600 to 800 per hour are now possible with capacities of 12-20 ounces. Maximum mold size is 27" x 34" and plasticizing capacity is 150 lb. Addition of a transfer injection unit permits faster production, better quality and material savings. Write *Dept. SPE,* **The Fellows Gear Shaper Co., Springfield, Vermont.**

Tote Bin Now a Blender Too

The development of a Tote Tumbler has been announced where a tote bin is rotated by its diagonal corners effecting a close blend in about five minutes. It is used for the blending of virgin material with regrind and colour concentrates. Ask *Dept. SPE,* **Tote System Inc., Beatrice, Nebraska.**

Impact Mill

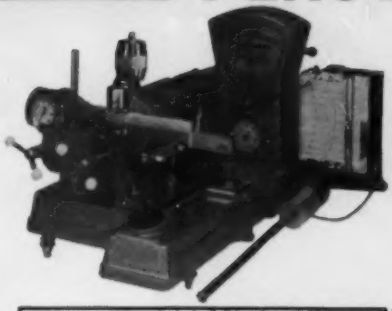


New stainless steel centrifugal impact mill furnishing about twice the energy of earlier models is now on the market. Contamination-free processing, rotor speeds to 5000 RPM and sealed construction for inert atmosphere operation are features to be noted. Contact *Dept. SPE,* **Entoleter, Inc., New Haven, Conn.**

C W BRABENDER

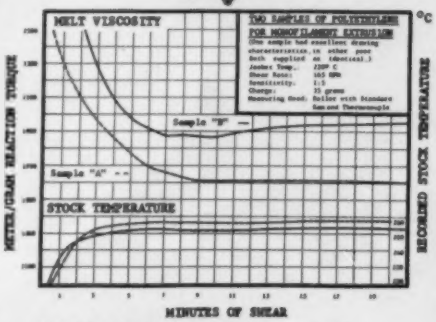
VARIABLE SHEAR RATE

PLASTI-CORDER™



THE CHEMICAL INDUSTRY'S MODEL OF THE TIME-PROVEN BRABENDER PLASTOGRAPH

Accurately forecasts processability as no other flow tester can! Now, under typical processing conditions with the C. W. Brabender Plasti-Corder, you can know the flow properties of all polymers before production begins... saving plant experimentation, scrap expense and down time.



Write for technical application bulletins.

SEE FOR YOURSELF!

Bring or send us your samples for FREE testing to determine...

- Molding and Extrusion Performance
- Polymer Stability
- Polymer Melt Flow at Various Shears
- Effect of Each Additive
- Decomposition Factors
- Temperature-Viscosity Relationship
- Production Rates

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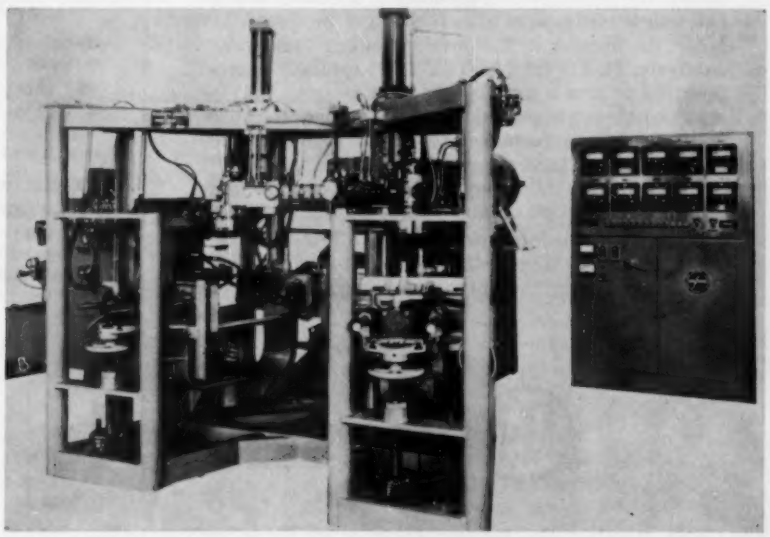
Piston Type Accumulators for Blow Molding

Mounted between the extruding head and the die the Xaloy-306-lined, 16000 pound plunger force accumulators act as material reservoirs and provide high pressure for fast parison extrusion. A continuous flow of material is thus permitted in the V-21 OHP Diversamatic blow molding machine. Write *Dept. SPE,* **Modern Plastics Machinery Corp., 64 Lakeview Ave., Clifton, N. J.**

Gel Time Meter

A new instrument has been introduced which accurately measures and records gel time regardless of the initial viscosity of the resin. This Mol-Rez Gel-Time Meter handles all chemical types and can be installed on a multiple basis. Quotations, *Dept. SPE,* **Mol-Rez Div., Amer. Petrochemical Corp., 3134 Calif. St. N. E., Minneapolis 18, Minn.**

MPM Blow Molding Machine



...why take risks on uneven catalyst activity?

Today, the most uniform economical urethane foams are being made with a new catalyst produced by M&T, the pioneer in the development of "one-shot" catalysts. This is CATALYST T-9,* specially manufactured to give a predictably high activity that is retained through normal storage and use. Because of its proved performance, M&T CATALYST T-9 has replaced stannous octoate in most "one-shot" systems, establishing new standards for fast and dependable reaction catalysis and foam uniformity.

Obtain more information about CATALYST T-9 by writing or calling Metal & Thermit Corporation, the only company that produces a complete line of tin catalysts.

*Pat. Applied For

M&T "ONE-SHOT" CATALYSTS INCLUDE:

M&T CATALYST T-9 (stannous type)
Stannous Octoate and Stabilized Stannous Octoate
M&T CATALYST T-12 (organotin type)
M&T CATALYST T-8 (dibutyltin di-2-ethylhexoate)

OTHER M&T PRODUCTS FOR PLASTICS:

THERMOLITE® Organotin Vinyl Stabilizers
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THERMOGUARD® H- High Tinctorial Strength Antimony Flame Retarder
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®Trade Mark

M&T Chemicals
METAL & THERMIT Corporation,

Sn Sb P
Si Ti Zr
inorganics and organometallics

POLYMER SCIENCE BOOK LIST—

expanded and revised list of books on all phases of plastics engineering compiled by SPE Education Committee

NEW BOOKS

Aero Research Ltd., Duxford, England, *Structural Adhesives: Theory and Practice of Gluing with Synthetic Resins,* Lange, Maxwell, and Springer, Ltd., London (1952).

Alexander, J., ed., *Colloid Chemistry Theoretical and Applied, Vol. VI,* Reinhold (1946).

Alfrey, T., Jr., *Mechanical Behavior of High Polymers,* Interscience (1948).

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American Gum Importers Association, Inc., *Natural Resins,* American Gum Importers Assn., Inc., New York (1936).

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Bettelheim, F. A., and others, *Molecular Organization in Solid High Polymers,* Academy of Sciences, New York (1959).

One of the many formidable projects recently undertaken by the SPE Education Committee under its Chairman, Dr. Charles C. Winding of Cornell University, was the revision of a polymer science book list first compiled in 1957. Published in the October 1957 issue of the SPE Journal (page 63), this original list had become incomplete in a relatively short time due to the great number of new books on plastics engineering published in the intervening 3½ years.

Early this year through the efforts of Dr. Brage Golding of the Education Committee and Purdue University, the original list was revised and expanded to include the most important U.S. and British publications. While every attempt has been made to include all books, it is recognized that this list, like its predecessor, can never be up to date due to continual publication of new and revised editions. Regardless, however, of these new publications, the list should provide a sound foundation upon which to build a well rounded and useful library on polymer science for either educational or research purposes.

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Billmeyer, F. W., Jr., *Textbook of Polymer Chemistry,* Interscience (1957).

Bjorksten, J., Tovey, H., Harker, B., and Henning, J., *Polyesters and Their Applications,* Reinhold (1956).

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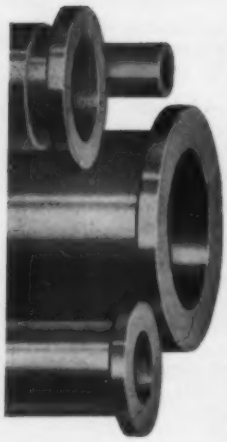
(Continued on p. 931)

only Xaloy

meets every requirement in extruder cylinders



1... **because** Xaloy *bimetallic cylinders* are available in *all* sizes, engineered to meet the individual requirements of plastics and rubber processors.

2... **because** the mirror-smooth surface of Xaloy liners allows maximum production, hour after hour, in continuous service.

3... **because** Xaloy cylinders have proven to be the most advanced liners for extrusion machines over the past 25 years.

WRITE FOR NEW XALOY DATA GUIDE

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Division of Honolulu Oil Corp.
961 East Slauson Ave.
Los Angeles 11, Calif.

SOCIETY CONSTITUTIONAL AMENDMENTS ADOPTED BY LETTER BALLOT

New Constitutional Law, C-48, covering dissolution of the Society, and amended Constitutional Law, C-25, including the two immediately surviving Past Presidents as Councilmen-at-Large, were adopted by overwhelming vote by letter ballot of the SPE membership according to the report of the three Tellers. The three Tellers who met at the Executive Office in Stamford on June 19 to validate the letter ballot are; G. Palmer Humphrey, New York Section; Edward Ferrari, Connecticut Section; and Richard M. Pascale, Newark Section.

There were 3,676 ballots received of which 5 were invalid or a total of 3,671 valid ballots. The vote on C-48 was 3,641 for adoption, 30 against adoption. On C-25, 3,609 were for adoption, 51 against.

Following are the new Constitutional Law C-48 and the amended Constitutional Law C-25.

ARTICLE XV—DISSOLUTION

C-48 In the event of the dissolution of this corporation, all of its assets not required for the payment of debts and taxes shall be transferred and delivered to United Engineering Center or to such other corporation as in the judgment of the appropriate court of the State of Michigan will best accomplish the general purposes for which this corporation was organized.

C-25 Council shall consist of representatives elected by members affiliated with Sections as provided in the By-Laws, and the two immediate surviving Past Presidents as Councilmen-at-Large, and a Councilman or Councilmen-at-Large as may be provided in the By-Laws. Each Councilman shall be a voting member of the Society when seated. The Executive Secretary shall be a non-voting member of Council.

As soon as the Society's Articles of Incorporation with the State of Michigan are amended to include the required dissolution law, the Society will apply to the Internal Revenue Service for tax classification 501.c3.

(Continued from p. 929)

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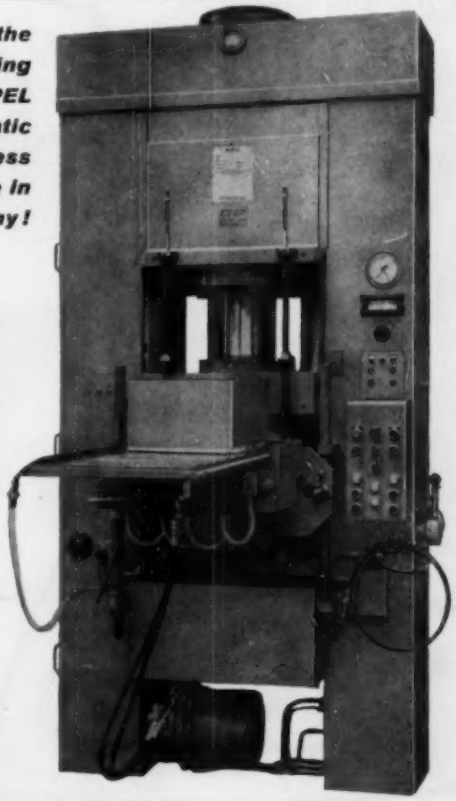

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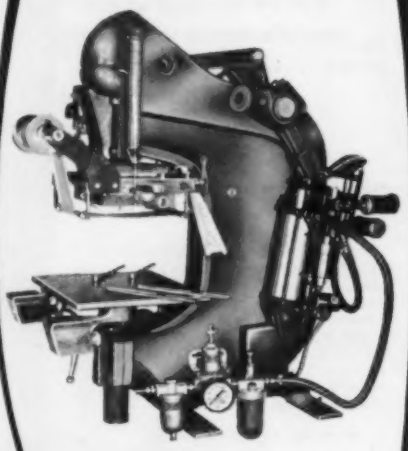

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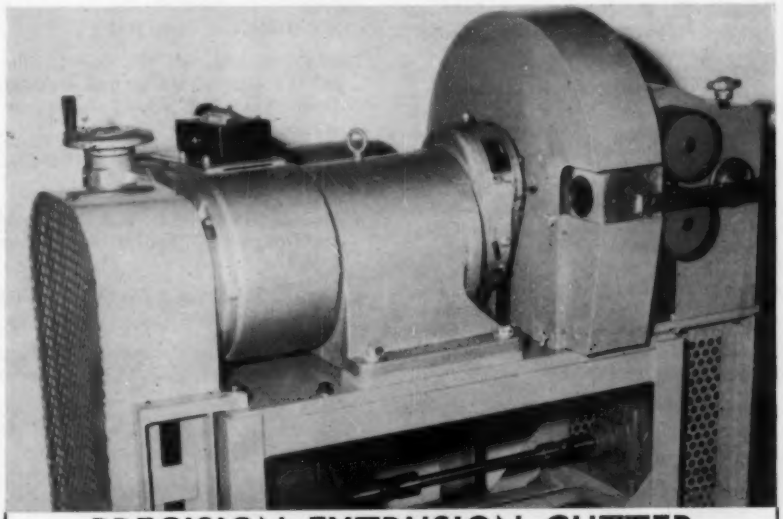

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Employment & Service Guide

POSITIONS OPEN

PLASTICS DEVELOPMENT ENGINEER

We have an attractive opening in our New Product Development Dept. for an engineer or chemist to work on fabrication techniques for new thermoplastics. B.S. minimum, 3-10 years broad experience in fabrication of plastics, especially extrusion. Send resume in confidence to Dr. David M. Clark, Director of Technical Recruiting, W. R. Grace & Co., Research Division, Clarksville, Md.

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Our expanding operations require the immediate employment of two technical sales representatives with 2-5 years experience in field sales. Locations—New York area and Chicago area. Requirements—chemical or chemical engineering degree, experience in sales of chemical intermediates preferably to plasticizer and plastics industries. Send resumé to Mr. A. J. Lacazette, Manager Plastic Intermediates Sales, Petrochemical Department, Continental Oil Company, 1270 Avenue of the Americas, New York 20, New York.

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American Molding Powder & Chemical Corp. 712
Ankerwerk International/Krauss-Maffei International 715
Argus Chemical Corp. 758
B. I. P. Engineering Ltd. 931
The Black-Clawson Co. 915
C. W. Brabender Corp. 927
Cadet Chemical Corp. 755
Celanese Polymer Co. 705, 706
Columbian Carbon Co. 772
Crucible Steel Co. of America 770
Curtiss-Wright Corp., Princeton Div. 718
Davis-Standard ..... Cover 2
D-M-E Corp. 707
Dow Corning Corp. 742
Durez Plastics Div., Hooker Chemical Co. 749
Frank W. Egan & Co. 926
Enjay Chemical Co., Div. Humble Oil & Refining Co.
Chemicals 714
Polypropylene 916
Foster & Allen, Inc. 933
General Chemical Div., Allied Chemical Corp. 922, 923
Gering Plastics, Inc., Div. Studebaker-Packard Corp. 774
B. F. Goodrich Co., Geon Div. 748
Goodrich-Gulf Chemicals, Inc. 740, 741
W. R. Grace & Co., Polymer Chemicals Div. 728
Harshaw Chemical Co. 920
Hooker Chemical Co., Durez Plastics Div. 749
Improved Machinery Inc. 738
Industrial Research Laboratories 930
Injection Molders Supply Co. 734
Johnson Mfg. Co. 917
Kensol-Olsenmark, Inc. 932
Kentucky Color & Chemical Co. 724
Metal & Thermit Corp. 928
Midland-Ross Corp., Waldron Hartig, Div. 921
Monsanto Chemical Co.
Organic Chemicals Div. 720, 721
Plastics Div. 710, 711
National Aniline Div., Allied Chemical Corp. 771
National Distillers & Chemical Corp., U. S. Industrial Chemicals Co., Div. 924
National Rubber Machinery Co. 918
Newark Die Co. 716
Newark Die Hobbing & Casting Co. 717
Nopco Chemical Co. 776
Olympia Tool & Machine Co. 917
Chas. Pfizer & Co.—Industrial 750
Phillips Chemical Co. 722
Plastic Molders Supply Co. 754
Prodex Corp. 730
Reifenhauser U. S. Sales 926
L. W. Reinhold Plastics, Inc. 729
Rona Pearl Corp. 755
A. Schulman, Inc. ..... Cover 4
Sterling Extruder Corp. 727
Sterling, Inc. 938
Studebaker-Packard Corp., Gering Plastics, Inc., Div. 774
Swift and Co., Technical Products Dept. ..... Cover 3
Union Carbide Plastics Co., Div. Union Carbide Corp. 756, 757
U. S. Industrial Chemicals Co., Div. of National Distillers & Chemical Corp. 924
Waldron Hartig, Div. Midland-Ross Corp. 921
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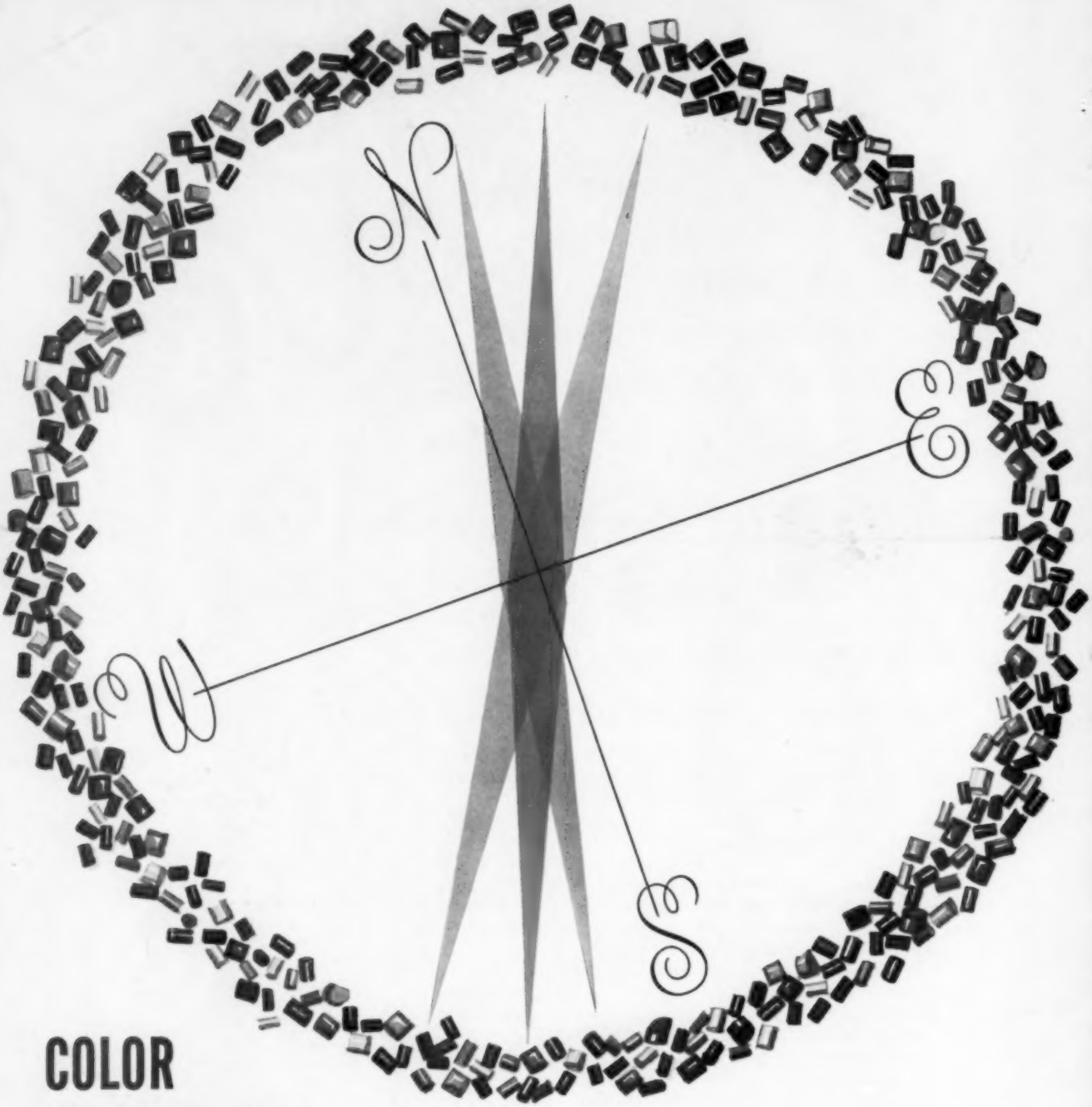

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